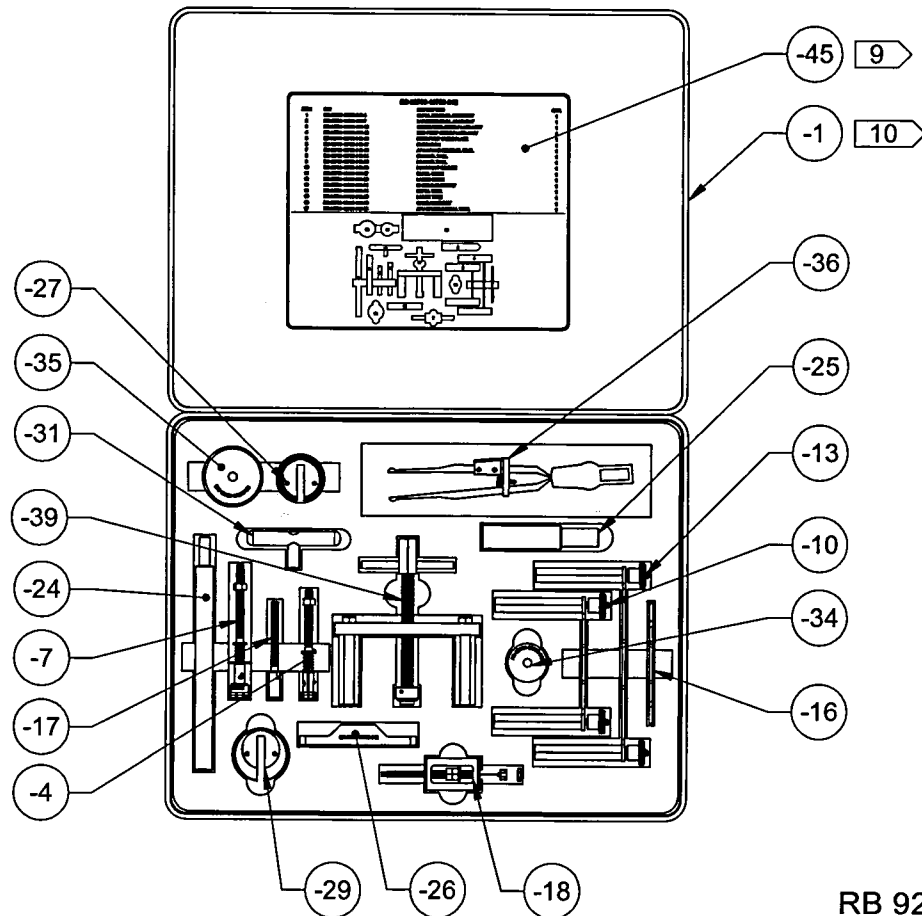
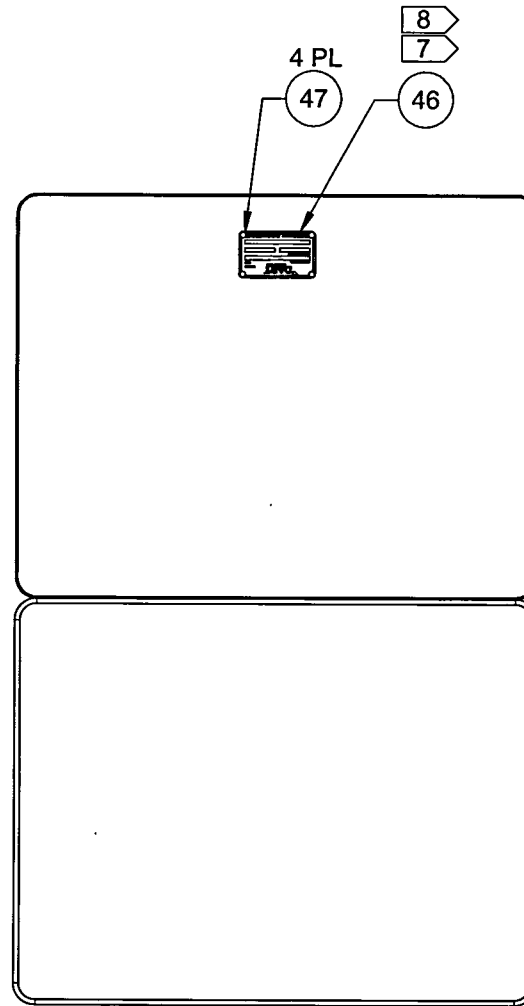


ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10753-042-1	PACKAGING ASSY
-4	1	RB 92700-10753-042-4	SMALL REMOVAL ASSEMBLY
-7	1	RB 92700-10753-042-7	LARGE REMOVAL ASSEMBLY
-10	1	RB 92700-10753-042-10	GENERATOR GUIDE PLATE ASSY
-13	1	RB 92700-10753-042-13	HYD PUMP GUIDE PLATE ASSY
-16	1	RB 92700-10753-042-16	LUBE PUMP GUIDE PLATE
-17	1	RB 92700-10753-042-17	EXTENSION
-18	1	RB 92700-10753-042-18	APU SPLINE REMOVAL TOOL
-24	1	RB 92700-10753-042-24	SM INSTL TOOL
-25	1	RB 92700-10753-042-25	LG INSTL TOOL
-26	1	RB 92700-10753-042-26	LUBE PUMP BRIDGE
-27	1	RB 92700-10753-042-27	SMALL GUIDE
-29	1	RB 92700-10753-042-29	LARGE GUIDE
-31	1	RB 92700-10753-042-31	HANDLE ASSEMBLY
-34	1	RB 92700-10753-042-34	SMALL TUBE
-35	1	RB 92700-10753-042-35	LARGE TUBE
-36	1	RB 92700-10753-042-36	GAGE ASSEMBLY
-39	1	RB 92700-10753-042-39	APU SPLINE INSTALL TOOL
-45	1	RB 92700-10753-042-45	POSITION PLACARD
46	1	RB41011	DART PLACARD
47	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



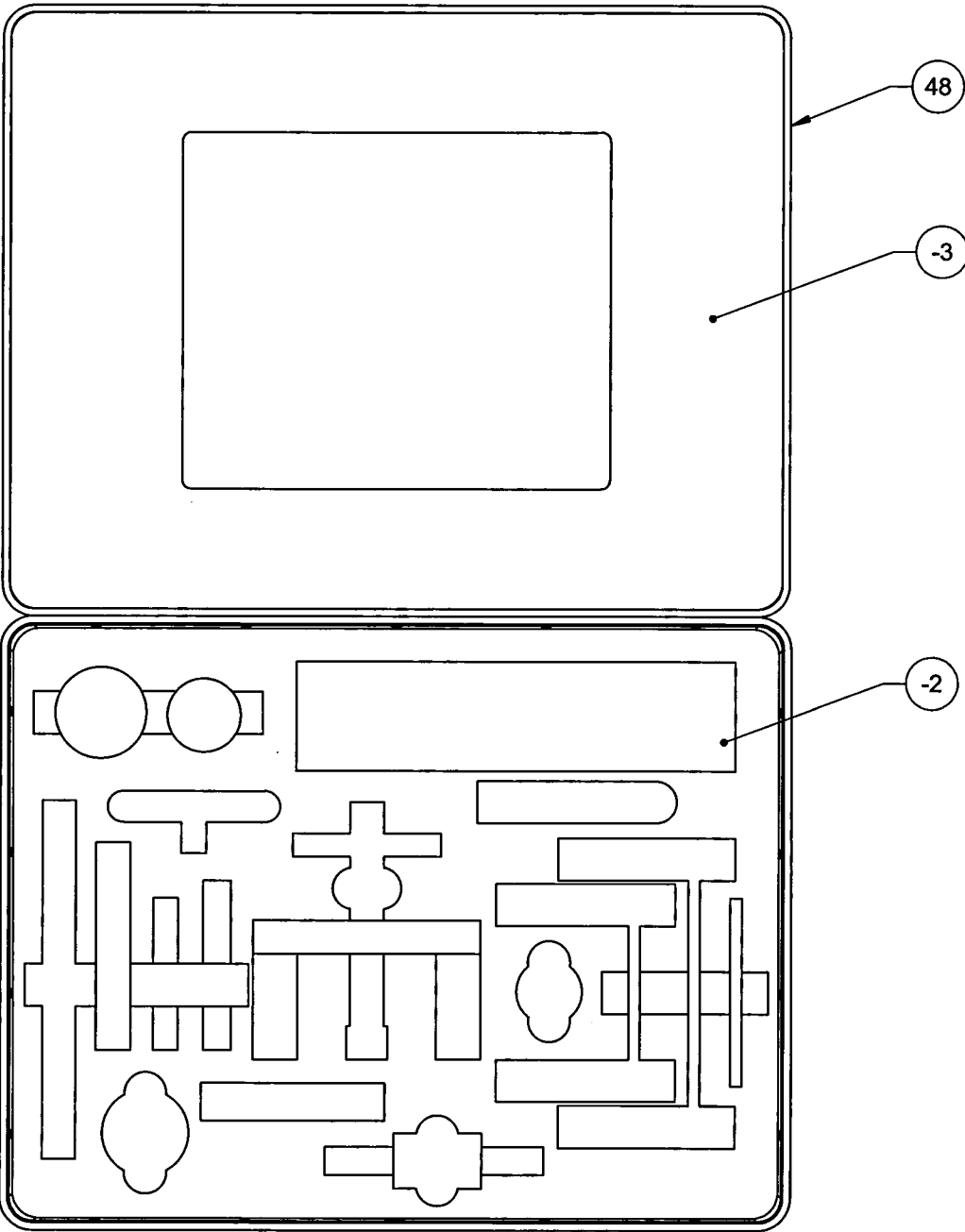
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
 - 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
 - 9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM
 - 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

RB 92700-10753-042 VESPEL SPLINE KIT



A	NEW ISSUE	18-621	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 1 OF 46
APPROVED	WY	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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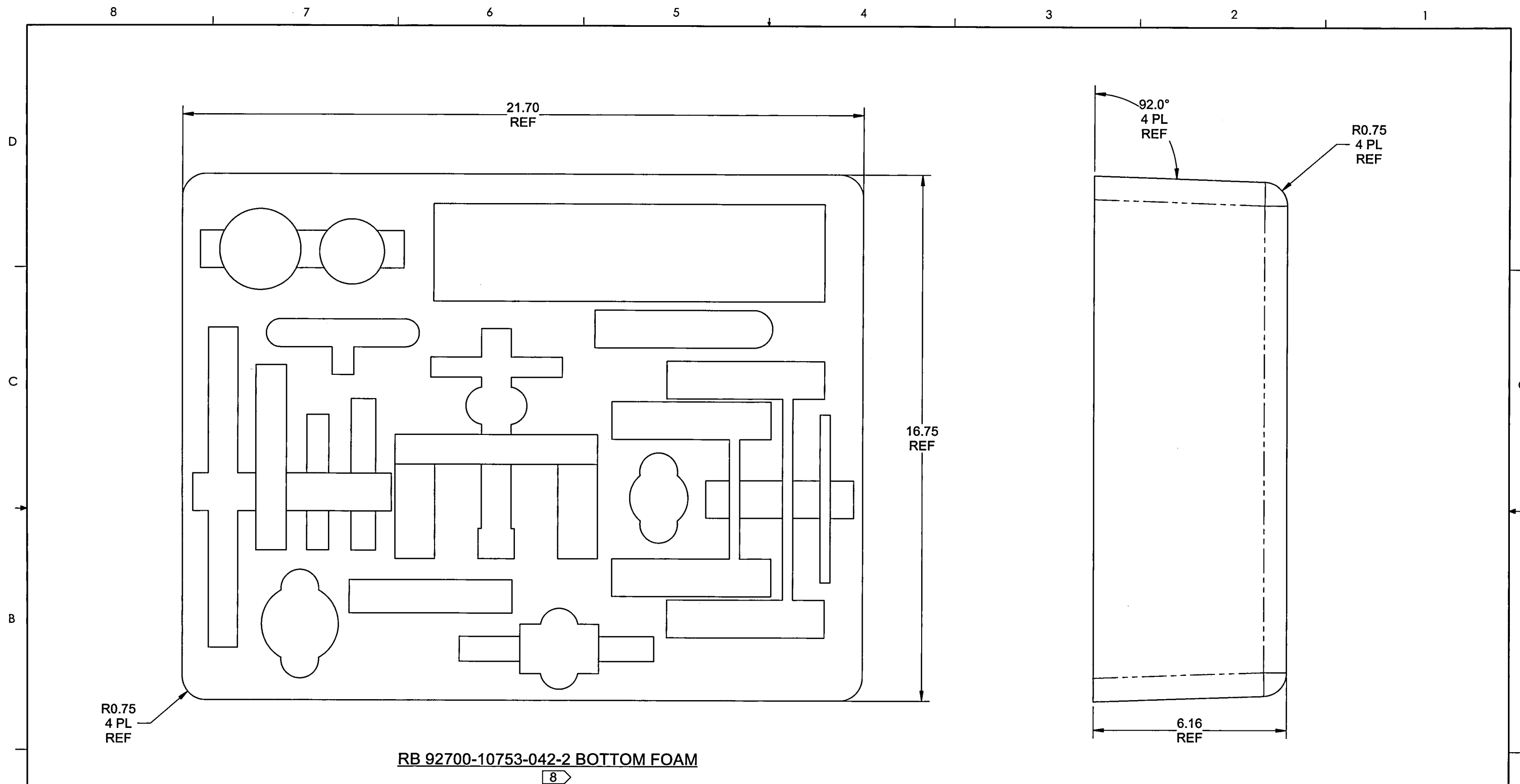
ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10753-042-2	BOTTOM FOAM
-3	1	RB 92700-10753-042-3	TOP FOAM
48	1	PELICAN #APP-1600-E	PELICAN CASE 1600



RB 92700-10753-042-1 PACKAGING ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 2 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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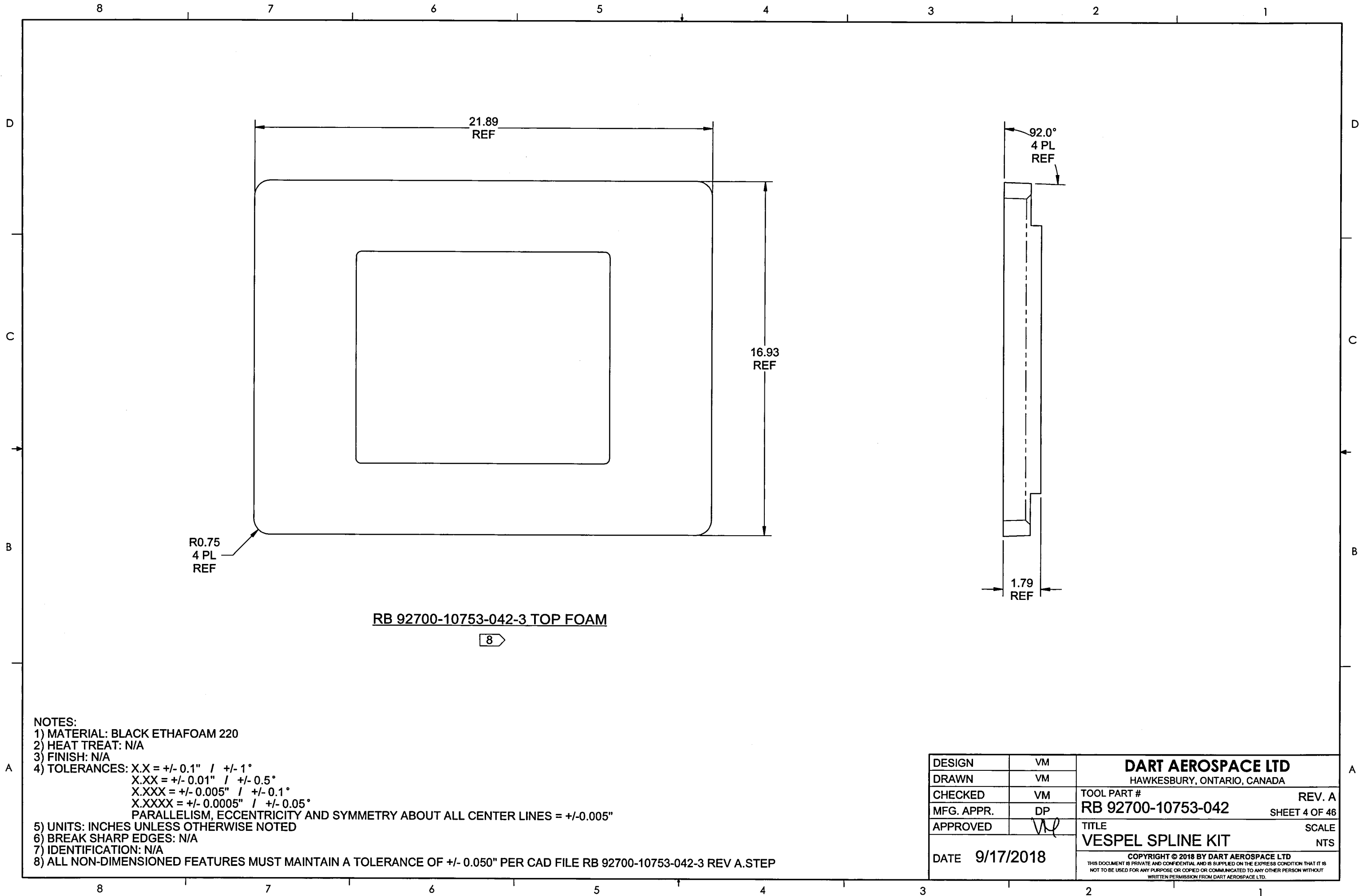
RB 92700-10753-042-2 BOTTOM FOAM

8

NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10753-042-2 REV A.STEP

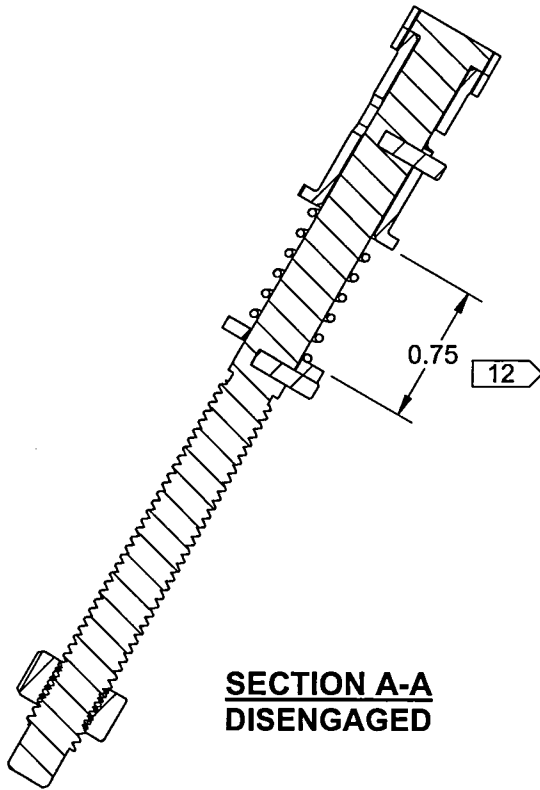
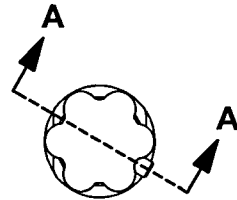
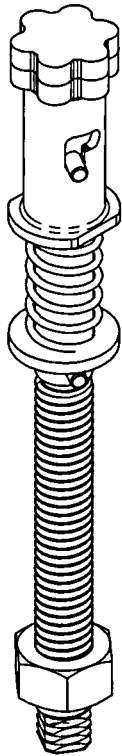
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 3 OF 46
APPROVED	W	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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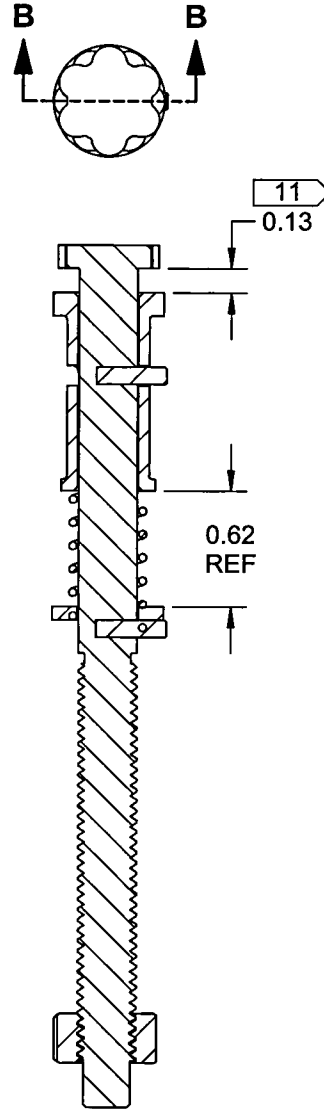
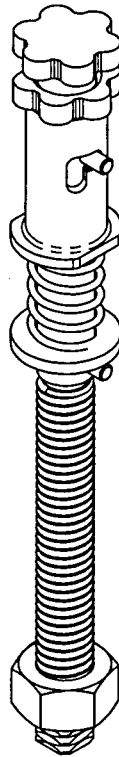
NOTES:
1) MATERIAL: BLACK ETHAFOAM 220
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10753-042-3 REV A.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 4 OF 46
APPROVED	W	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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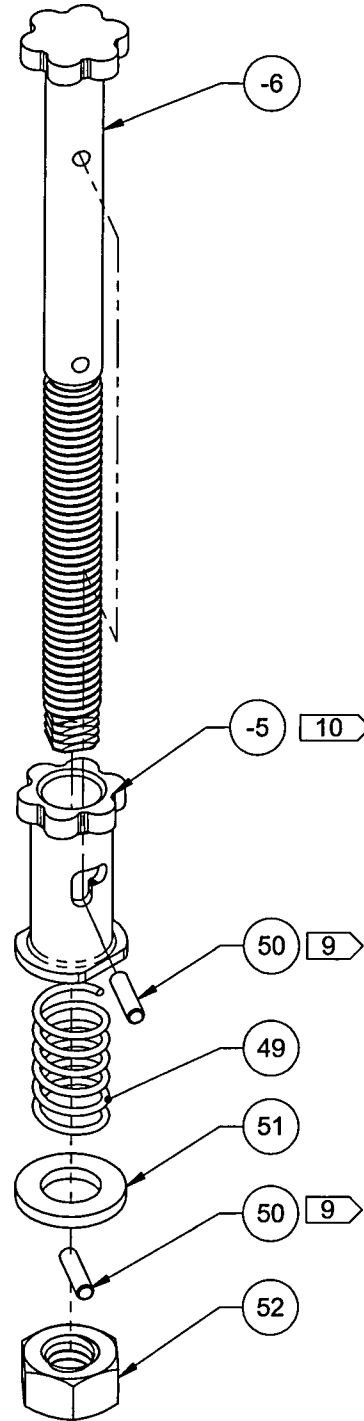
ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10753-042-5	COMPRESSION SLEEVE
-6	1	RB 92700-10753-042-6	PIN
49	1	TRAKAR#C1067-107-0191 OR EQUIV	SPRING
50	2	McMaster#98381A436 OR EQUIV	STEEL DOWEL PIN 3/32" DIA. x 3/8" LG.
51	1	McMaster#91922A305 OR EQUIV	STEEL FLAT WASHER FOR 5/16" SCREW 0.593" OD x 0.324" ID.
52	1	McMaster#94895A030 OR EQUIV	STEEL HEX NUT 5/16"-18



SECTION A-A
DISENGAGED



SECTION B-B
ENGAGED

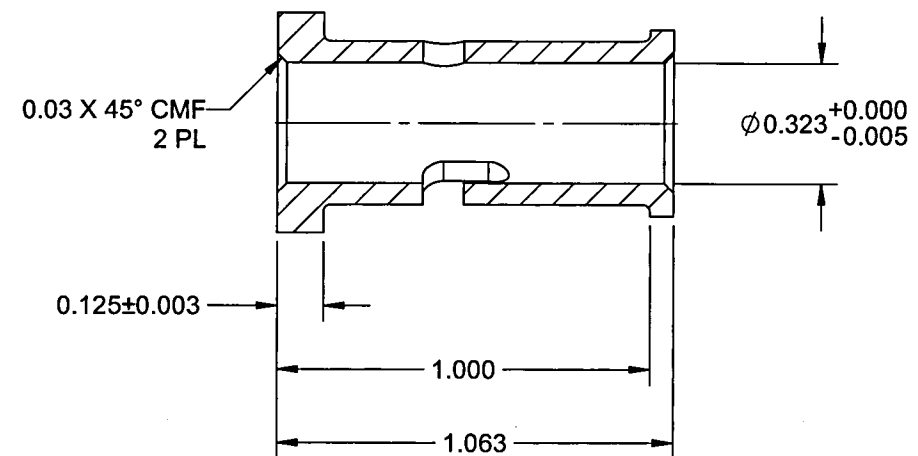
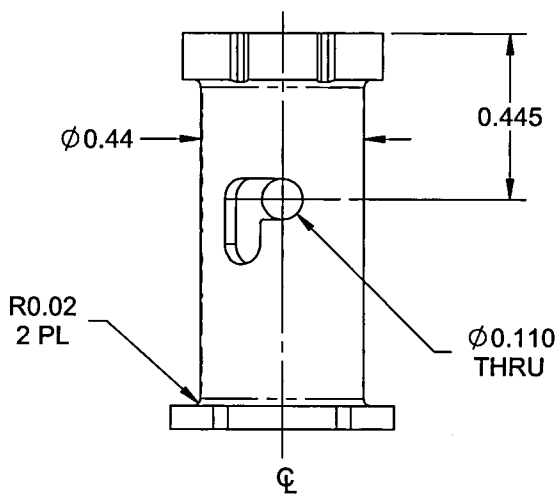
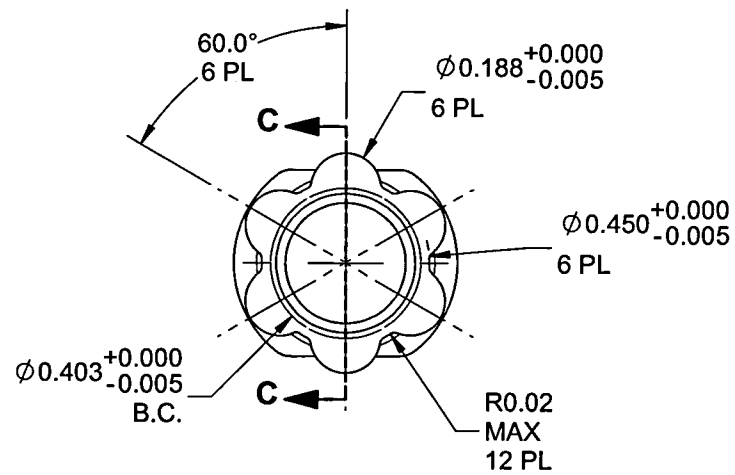
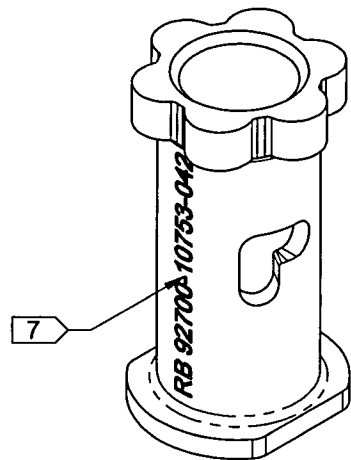


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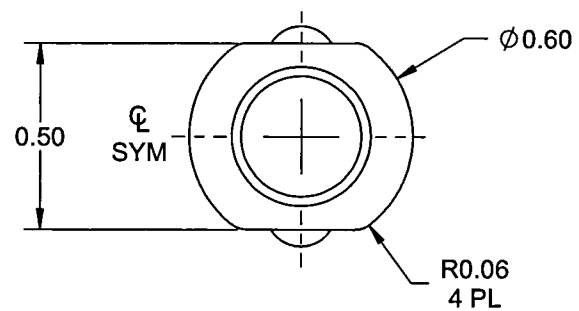
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 50 DOWEL PIN WITH ITEM -6 AND REMOVE EXCESS
- 10) ITEM -5 MUST MOVE FREELY
- 11) MUST HAVE THIS DIMENSION WHEN THE TOOL IS ENGAGED AND THE TEETH ARE UNALIGNED
- 12) MUST HAVE THIS DIMENSION WHEN THE TOOL IS NOT ENGAGED AND THE TEETH ARE ALIGNED
- 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG3

RB 92700-10753-042-4 SMALL REMOVAL ASSEMBLY

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 5 OF 46
APPROVED	W	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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SECTION C-C



RB 92700-10753-042-5 COMPRESSION SLEEVE

8

NOTES:

1) MATERIAL: 4140/4142

2) HEAT TREAT: 35-38 Rc

3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10753-042-5 REV A.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 6 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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8

7

6

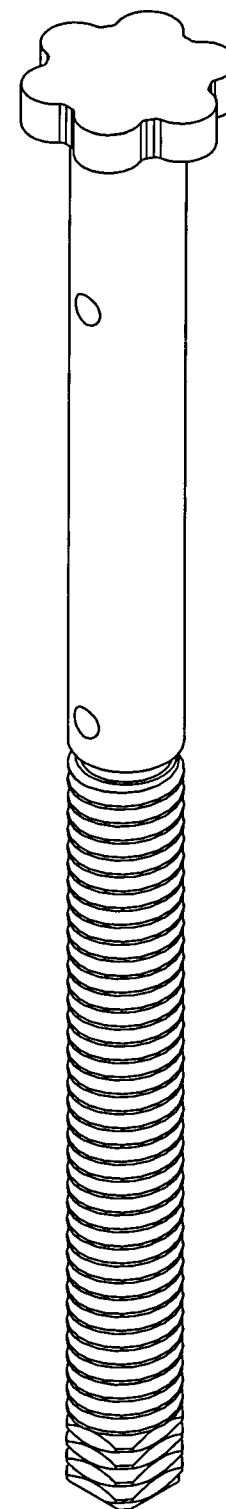
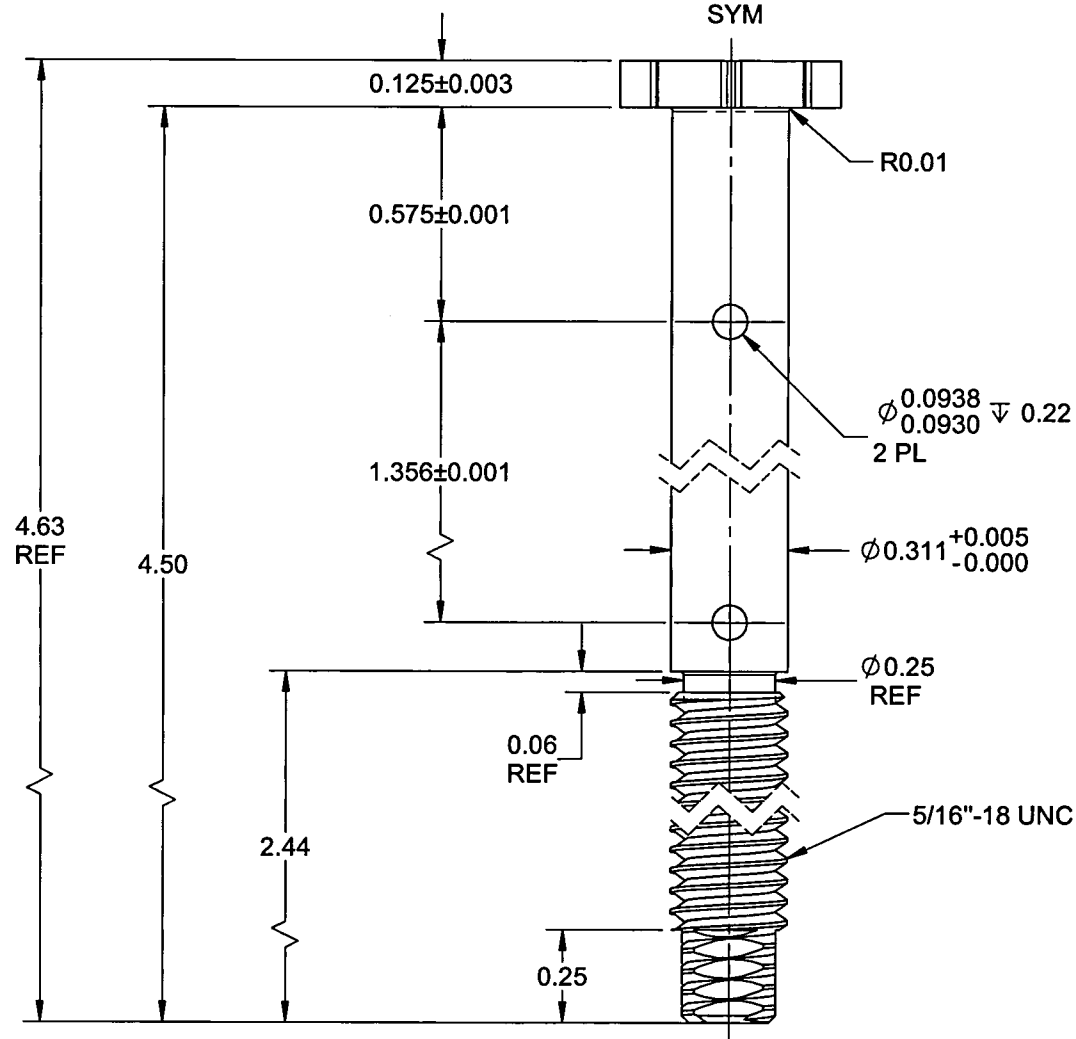
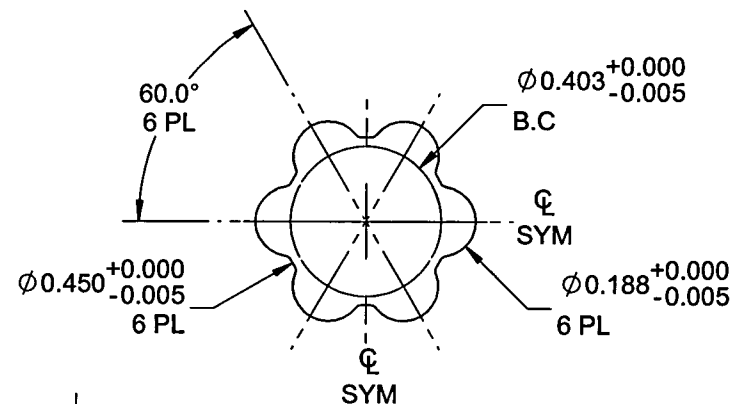
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4

3

2

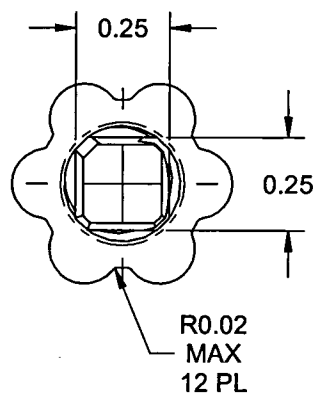
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RB 92700-10753-042-6 PIN

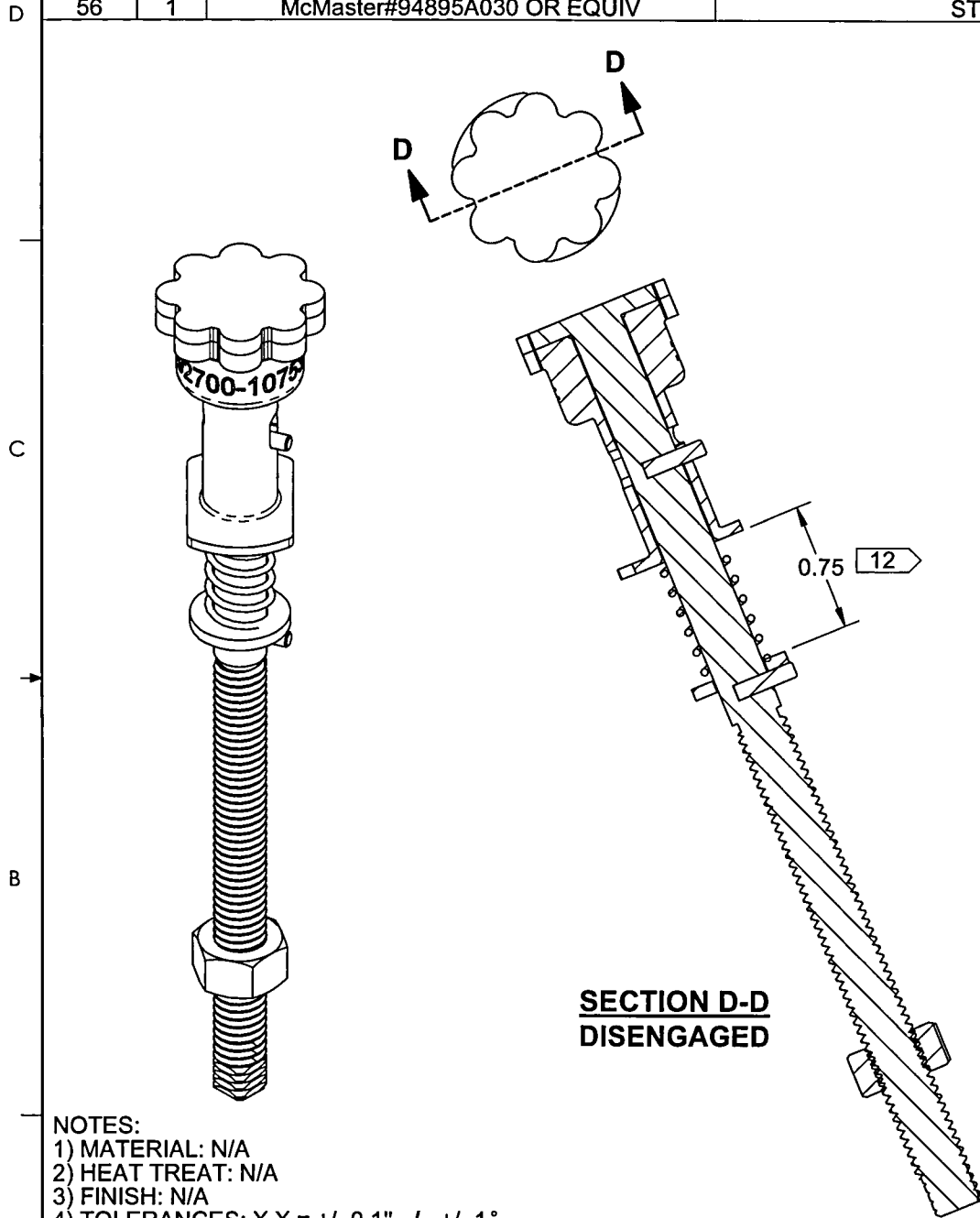
NOTES:

- 1) MATERIAL: 4140/4142
- 2) HEAT TREAT: 35-38 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A



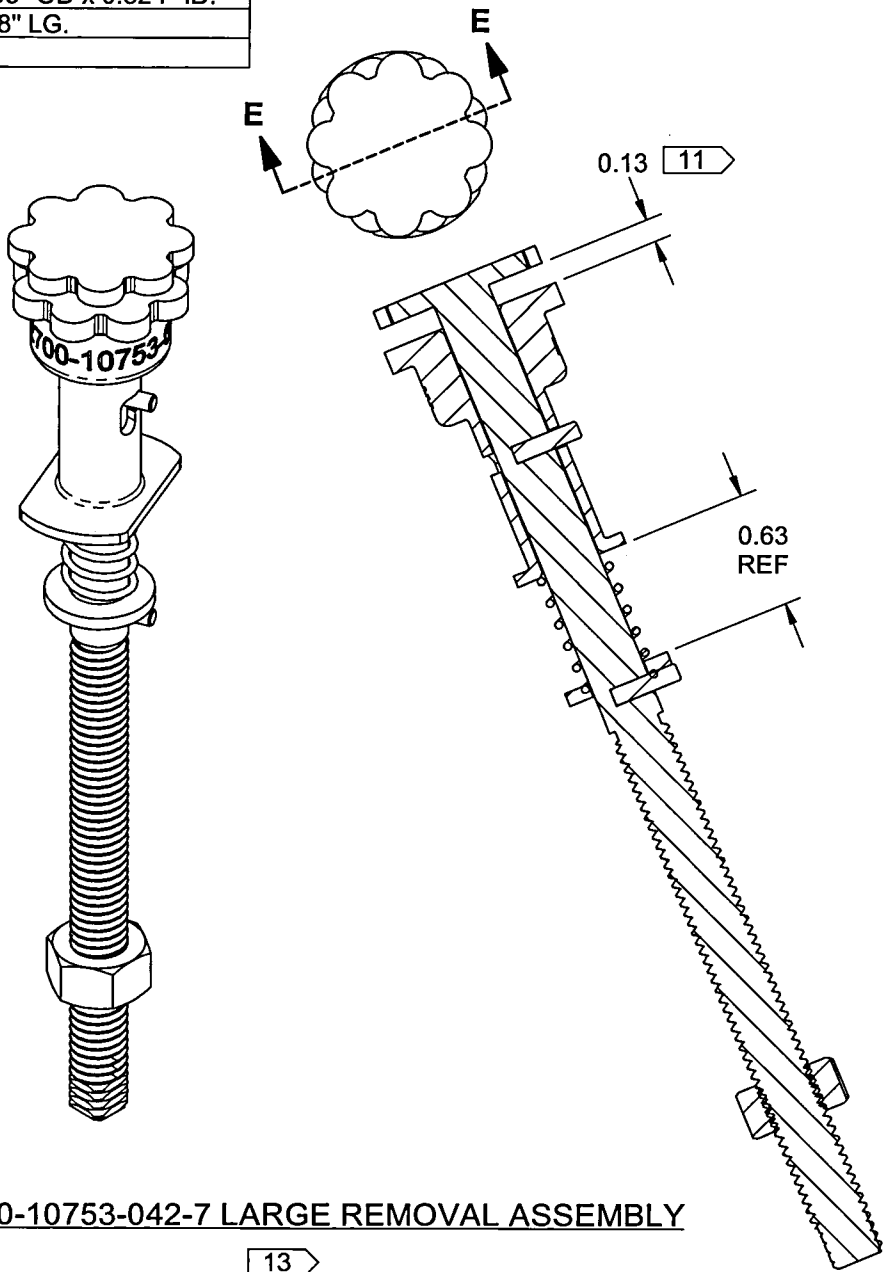
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 7 OF 46
APPROVED	VP	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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ITEM #	QTY	PART #	PART TITLE
-8	1	RB 92700-10753-042-8	PIN
-9	1	RB 92700-10753-042-9	COMPRESSION SLEEVE
53	1	TRAKAR#C1067-107-0191 OR EQUIV	SPRING
54	1	McMaster#91922A305 OR EQUIV	STEEL FLAT WASHER FOR 5/16" SCREW 0.593" OD x 0.324" ID.
55	2	McMaster#98381A436 OR EQUIV	STEEL DOWEL PIN 3/32" DIA. x 3/8" LG.
56	1	McMaster#94895A030 OR EQUIV	STEEL HEX NUT 5/16"-18

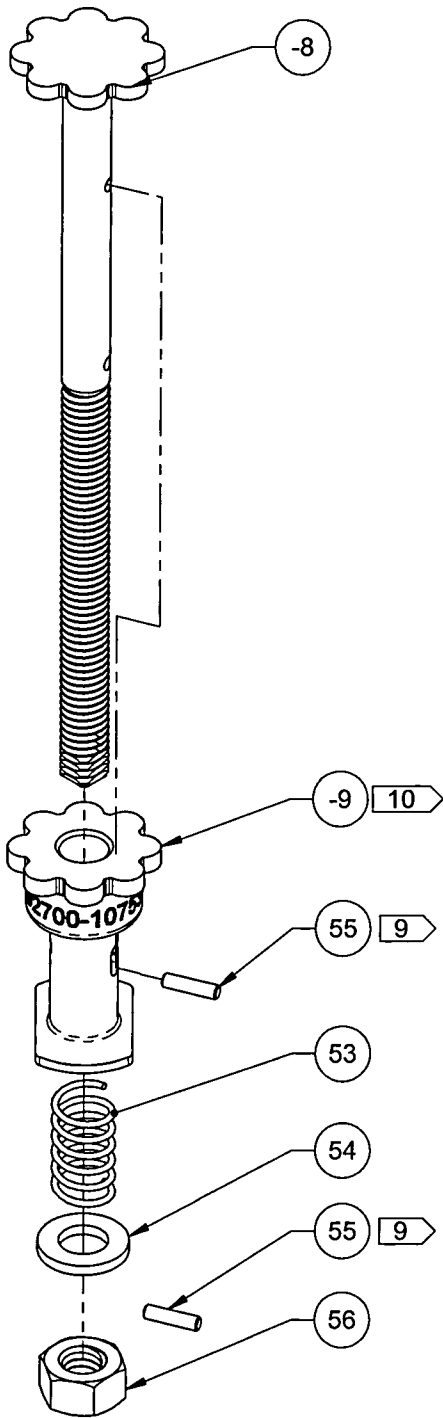


SECTION D-D
DISENGAGED

RB 92700-10753-042-7 LARGE REMOVAL ASSEMBLY

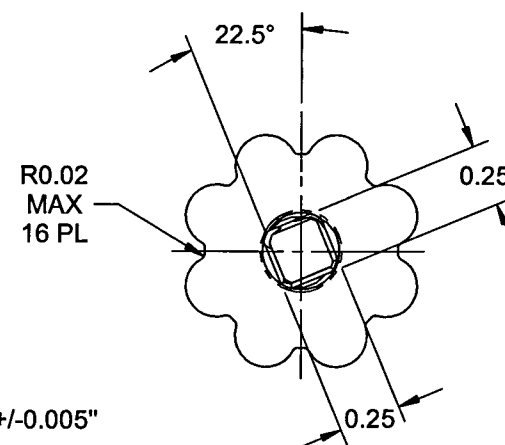
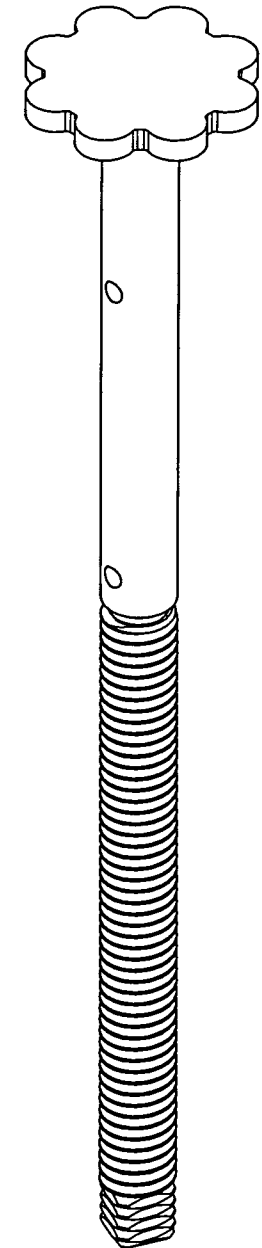


SECTION E-E
ENGAGED



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 55 DOWEL PIN WITH ITEM -8 AND REMOVE EXCESS
 - 10) ITEM -9 MUST MOVE FREELY
 - 11) MUST HAVE THIS DIMENSION WHEN THE TOOL IS ENGAGED AND THE TEETH ARE UNALIGNED
 - 12) MUST HAVE THIS DIMENSION WHEN THE TOOL IS NOT ENGAGED AND THE THEETH ARE ALIGNED
 - 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

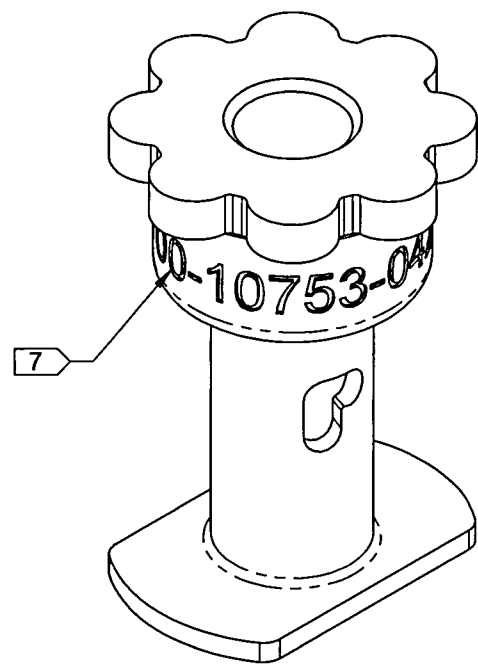
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 8 OF 46
APPROVED	VM	TITLE	SCALE
		VESPEL SPLINE KIT	NTS
DATE 9/17/2018		COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



NOTES:

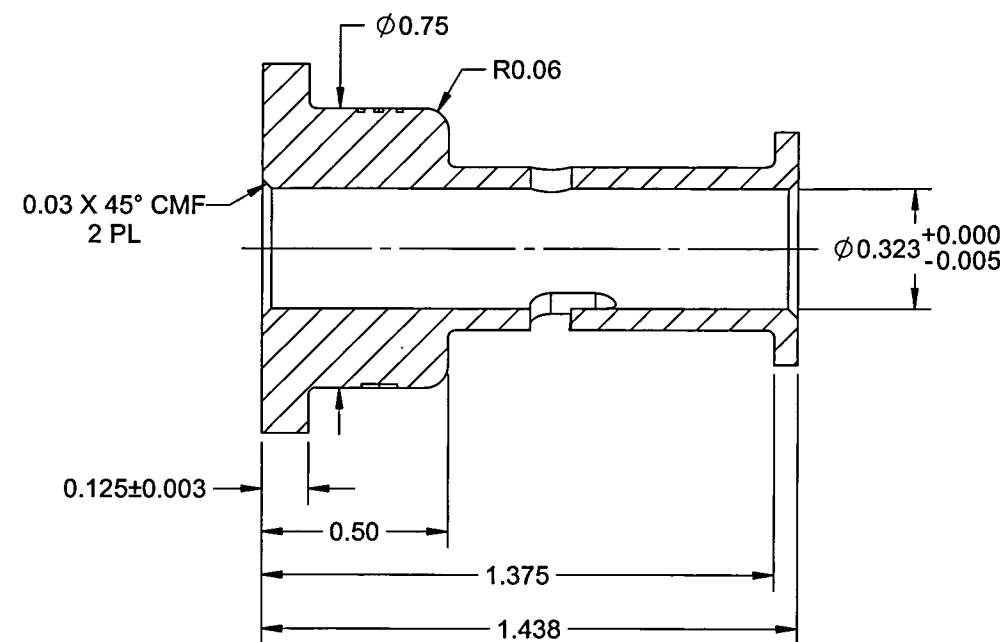
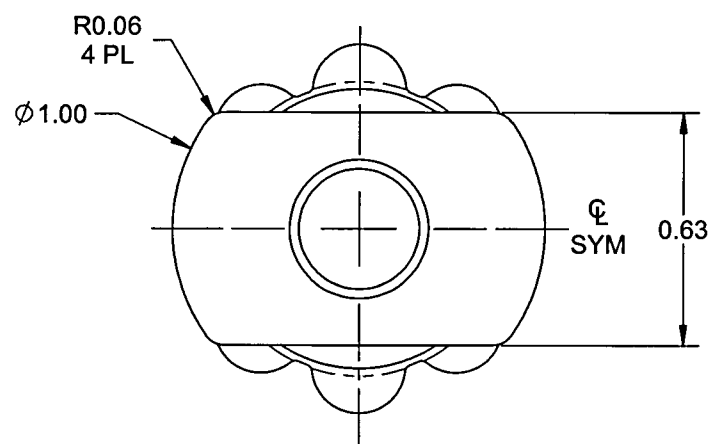
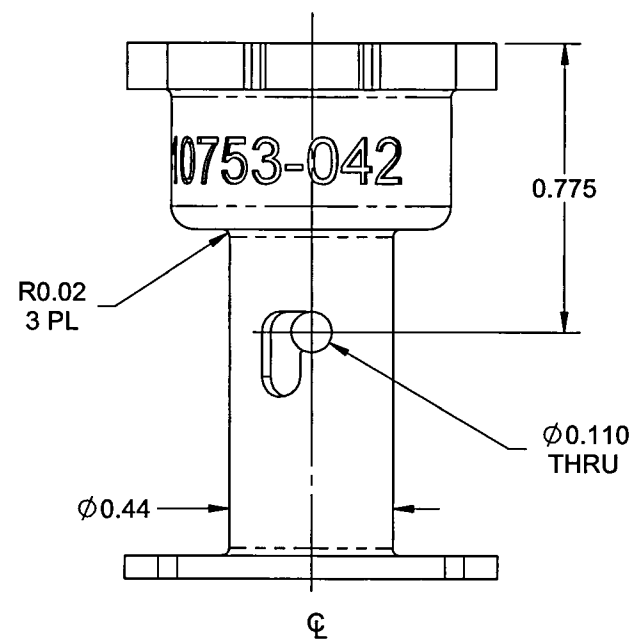
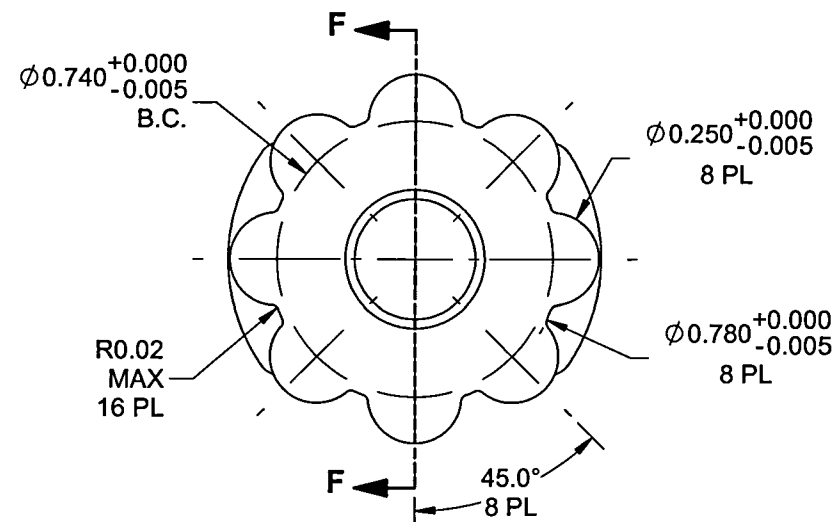
1) MATERIAL: 4140/4142	R0.02
2) HEAT TREAT: 35-38 Rc	MAX -
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	16 PL
4) TOLERANCES: X.X = +/- 0.1" / +/- 1° X.XX = +/- 0.01" / +/- 0.5° X.XXX = +/- 0.005" / +/- 0.1° X.XXXX = +/- 0.0005" / +/- 0.05° PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"	
5) UNITS: INCHES UNLESS OTHERWISE NOTED	
6) BREAK SHARP EDGES: 0.005" TO 0.010"	
7) IDENTIFICATION: N/A	

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 9 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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RB 92700-10753-042-9 COMPRESSION SLEEVE

8



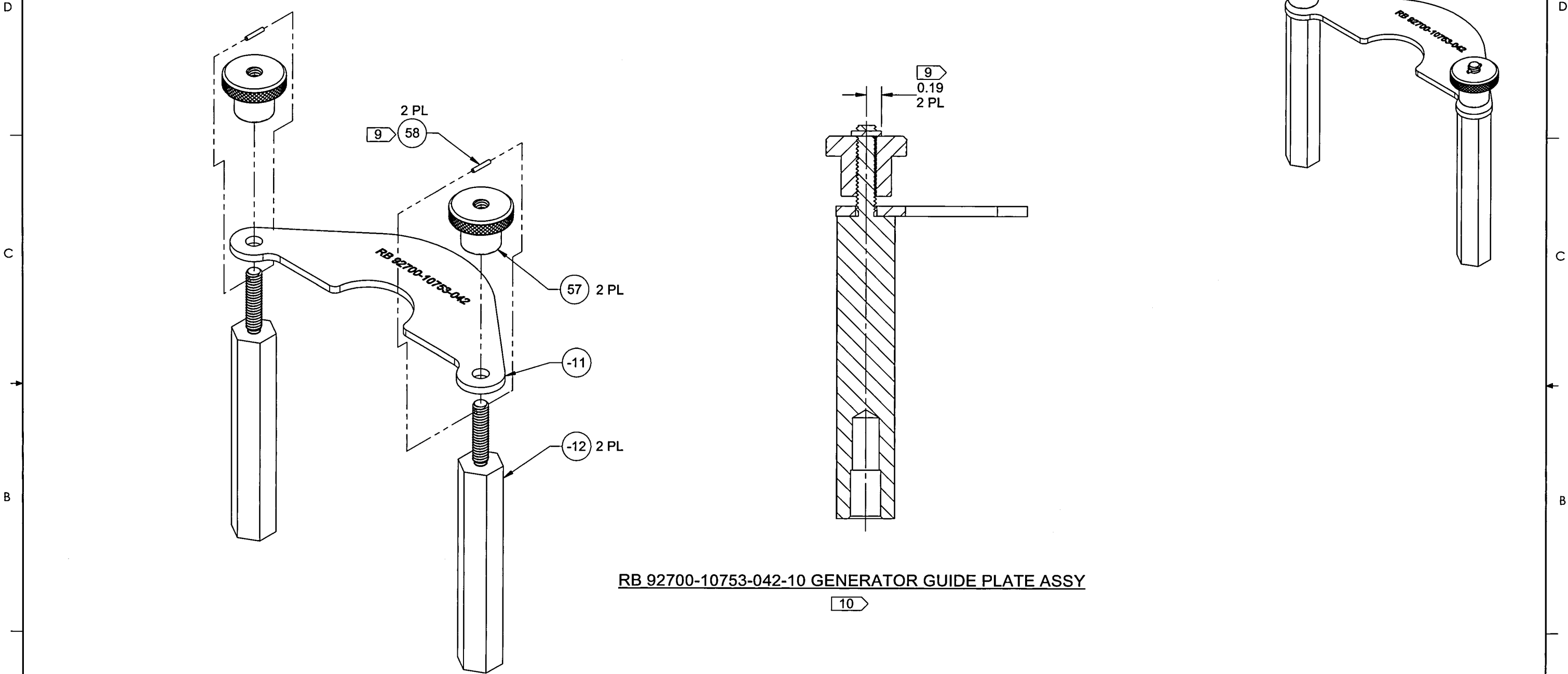
SECTION F-F

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: 35-38 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = $\pm 0.1^\circ$ / $\pm 1^\circ$
X.XX = $\pm 0.01^\circ$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005^\circ$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005^\circ$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005^\circ$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF ± 0.005 " PER CAD FILE RB 92700-10753-042-9 REV A.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 10 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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ITEM #	QTY	PART #	PART TITLE
-11	1	RB 92700-10753-042-11	PLATE
-12	2	RB 92700-10753-042-12	LEG
57	2	McMaster#6121K311 OR EQUIV	STEEL KNOB 1/4"-20 THREADED THRU HOLE
58	2	McMaster#98381A417 OR EQUIV	STEEL DOWEL PIN 1/16" DIA. x 3/8" LG.



RB 92700-10753-042-10 GENERATOR GUIDE PLATE ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 58 CENTERED WITH ITEM -12 AND REMOVE EXCESS
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 11 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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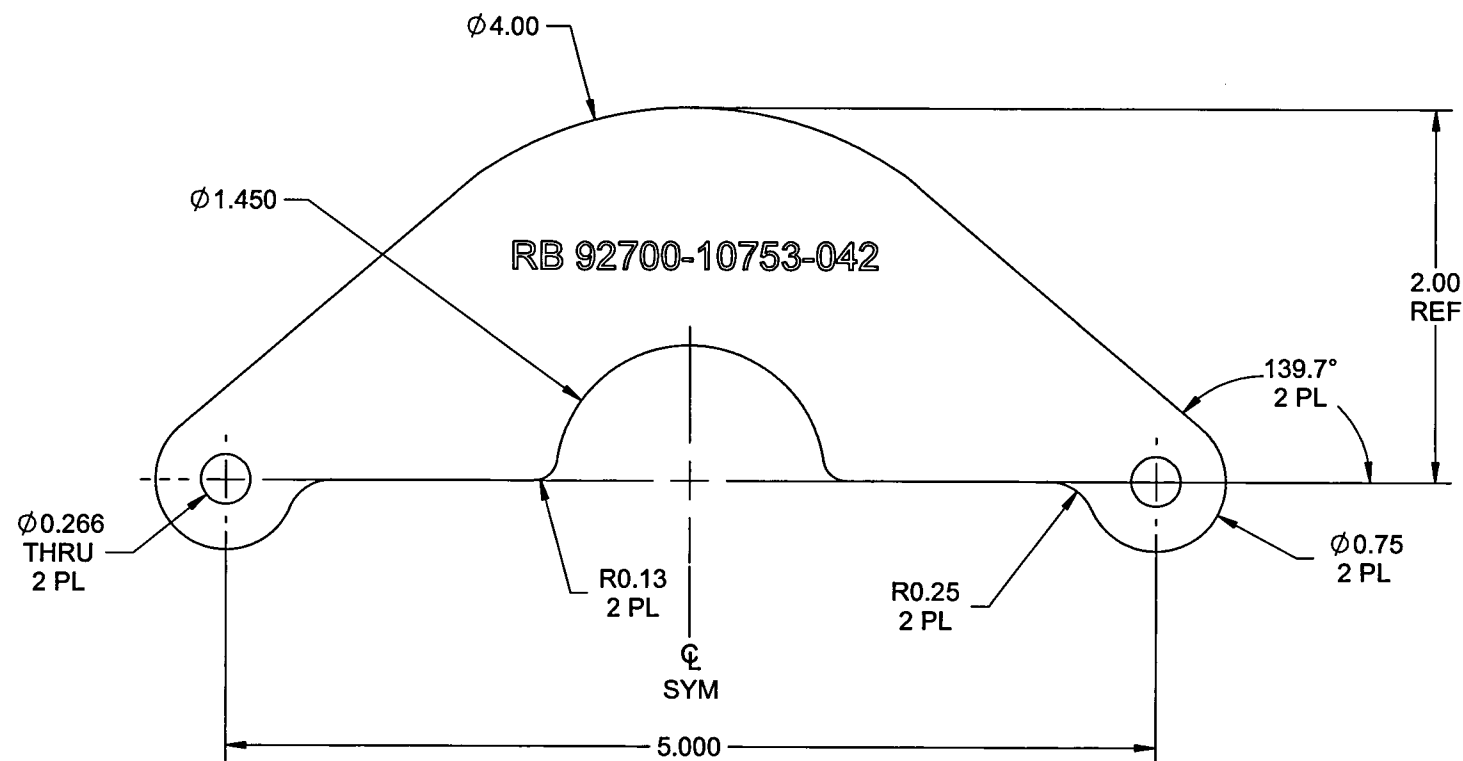
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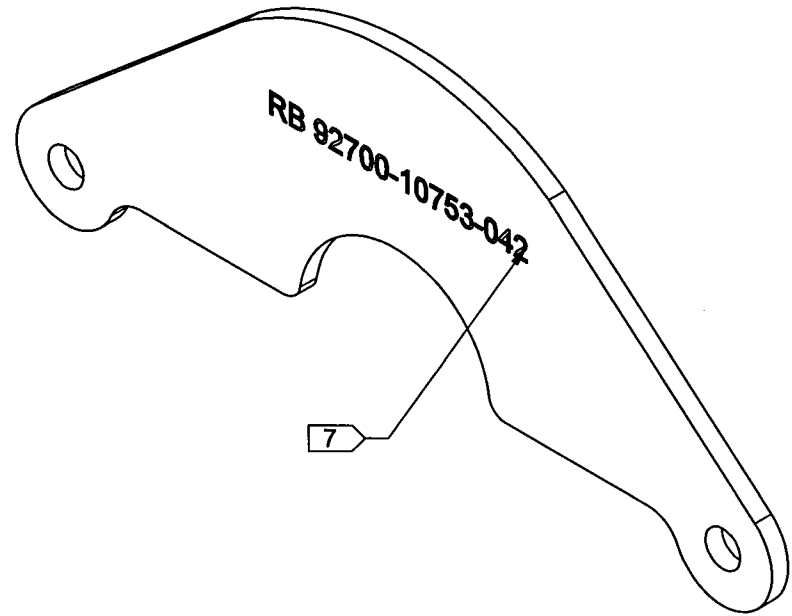
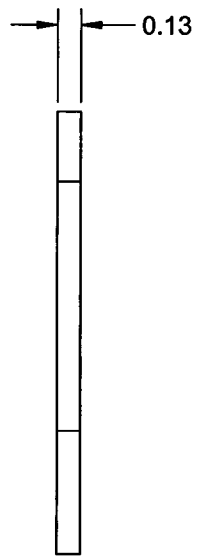
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RB 92700-10753-042-11 PLATE



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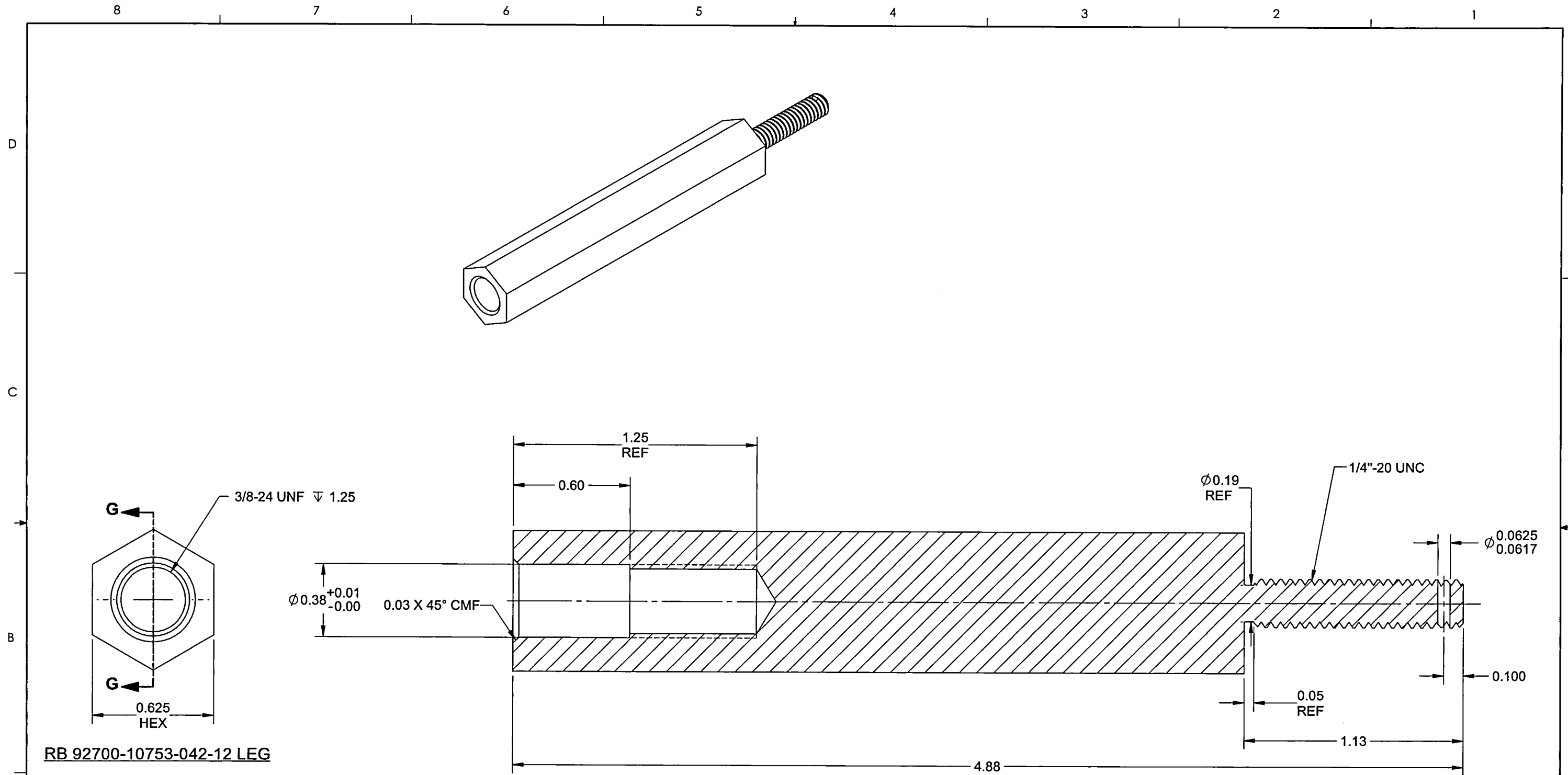
B

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- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 12 OF 46
APPROVED	VP	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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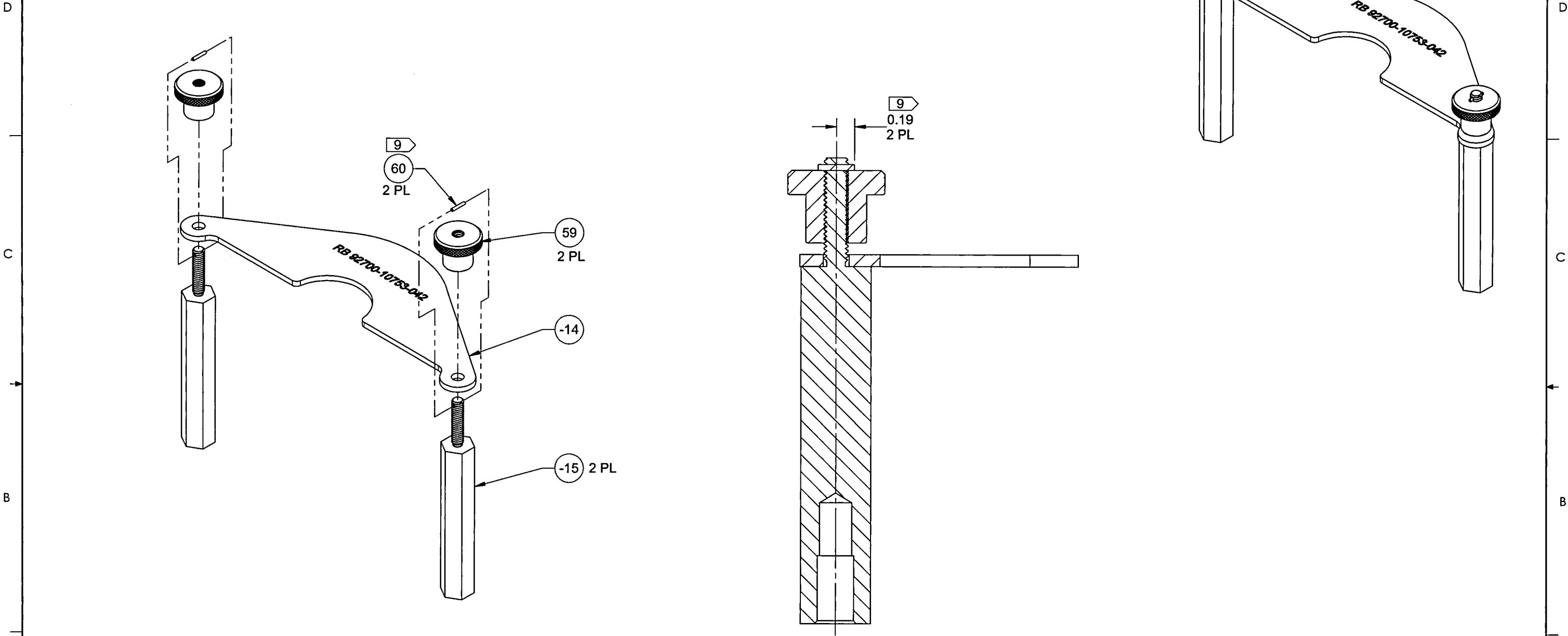


SECTION G-G

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 13 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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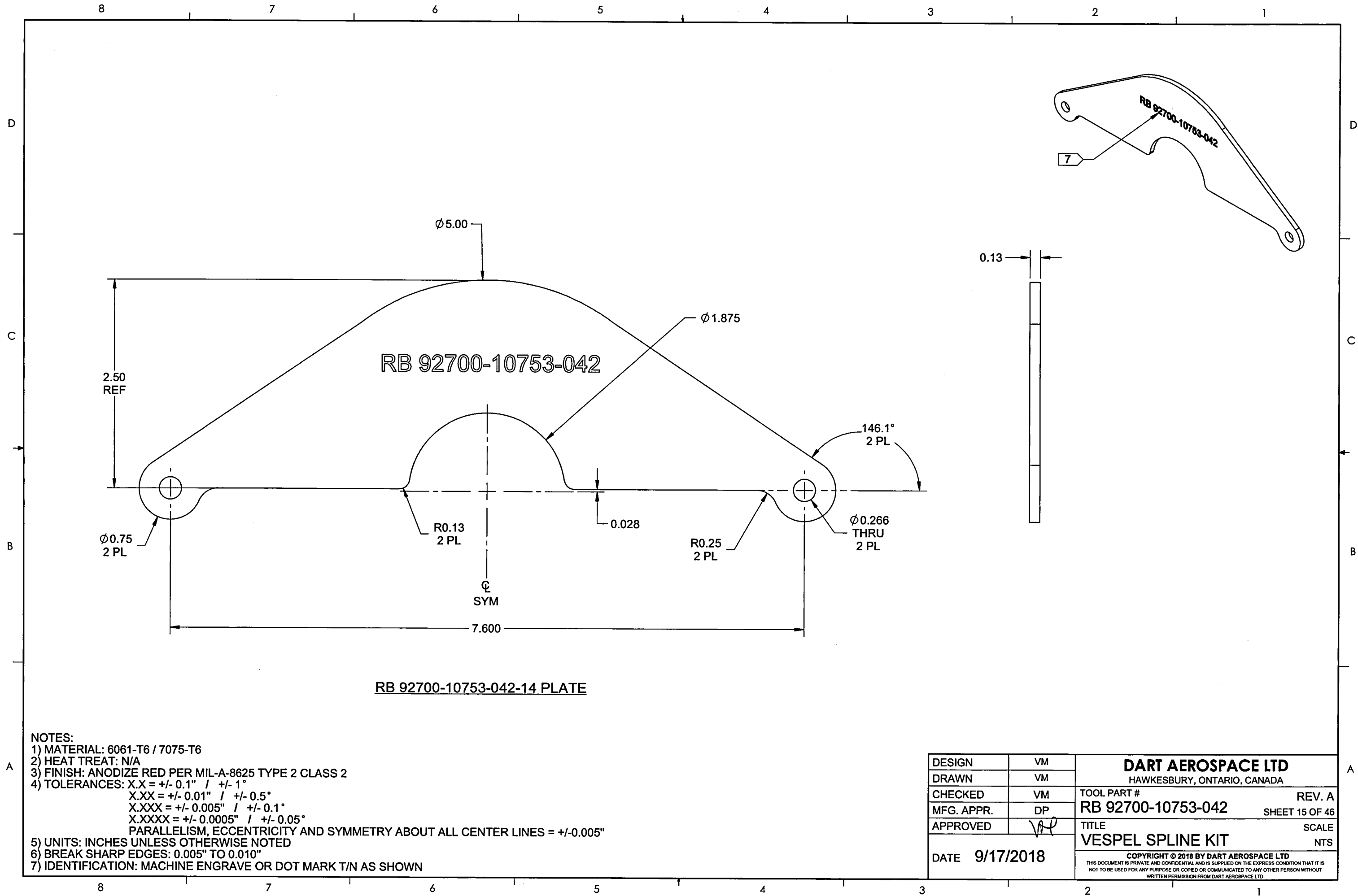
ITEM #	QTY	PART #	PART TITLE
-14	1	RB 92700-10753-042-14	PLATE
-15	2	RB 92700-10753-042-15	LEG
59	2	McMaster#6121K311 OR EQUIV	STEEL KNOB 1/4"-20 THREADED THRU HOLE
60	2	McMaster#98381A417 OR EQUIV	STEEL DOWEL PIN 1/16" DIA. x 3/8" LG.



RB 92700-10753-042-13 HYD PUMP GUIDE PLATE ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 60 CENTERED WITH ITEM -15 AND REMOVE EXCESS
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 14 OF 46
APPROVED	✓	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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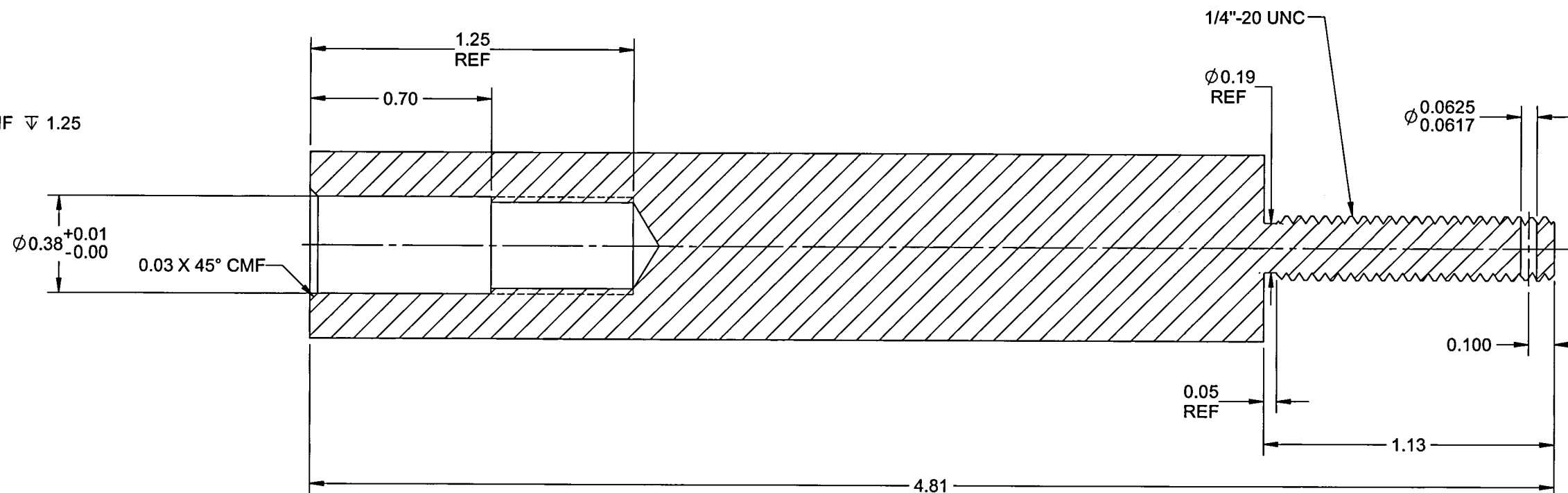
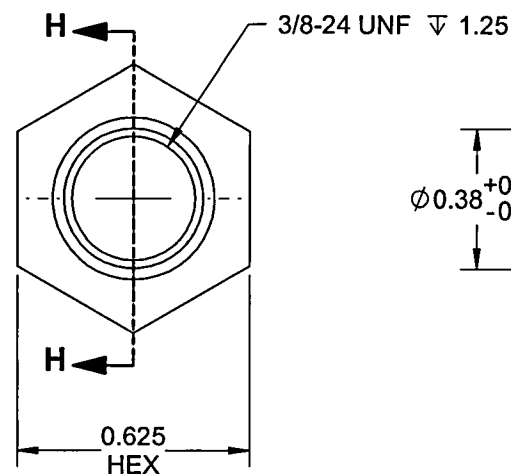
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RB 92700-10753-042-15 LEG

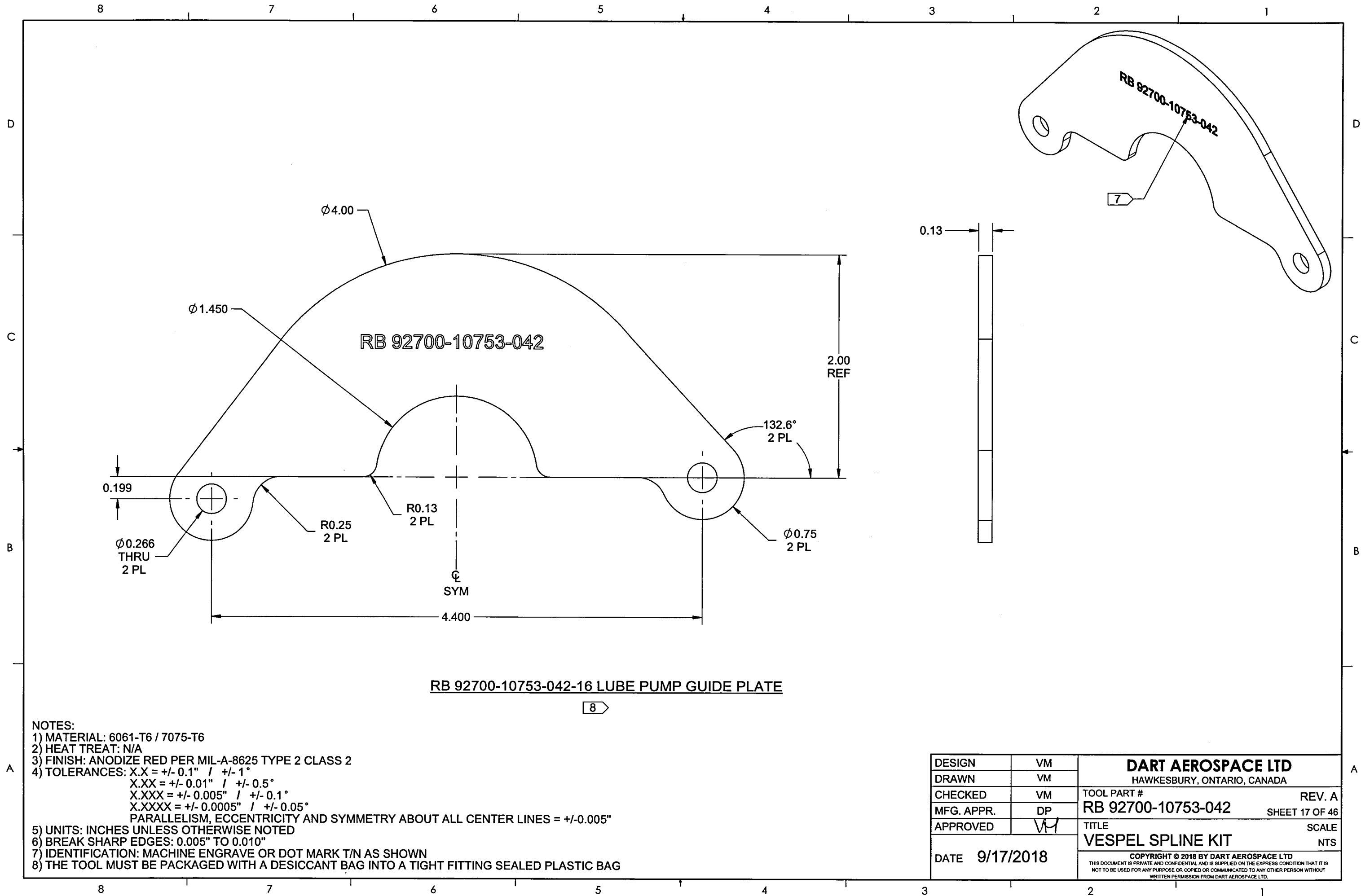
SECTION H-H

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 16 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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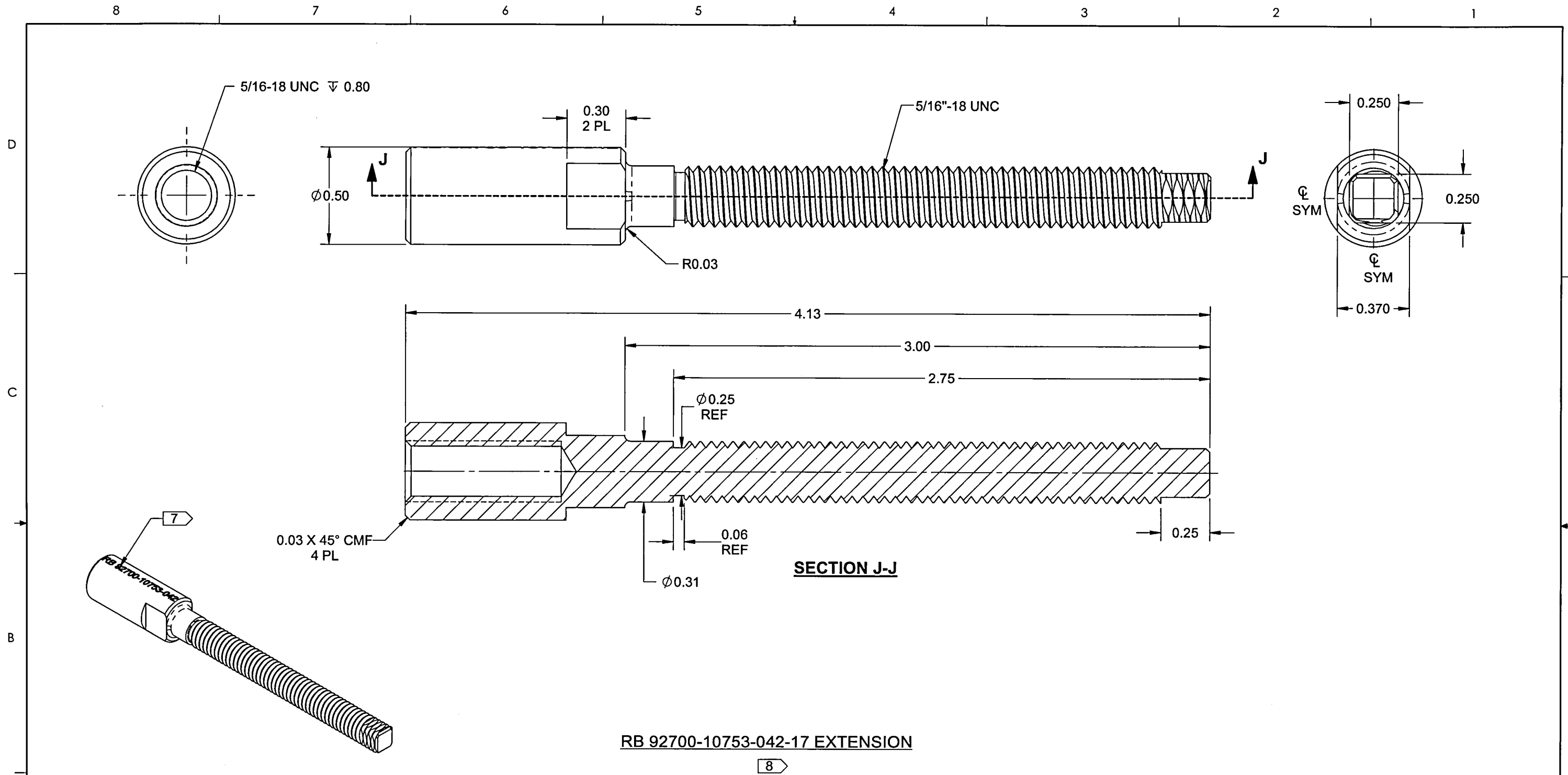
8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
X.XX = ± 0.01 " / $\pm 0.5^\circ$
X.XXX = ± 0.005 " / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
- 8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

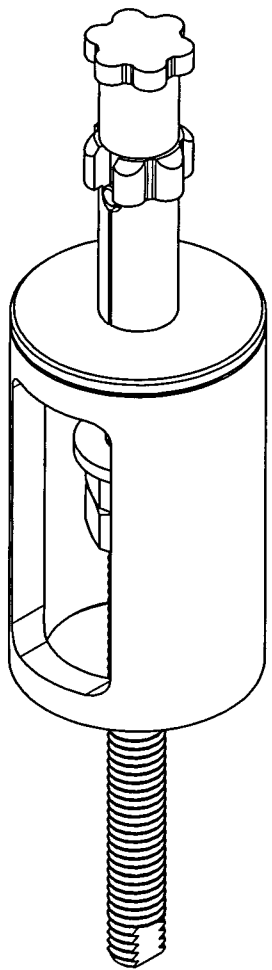
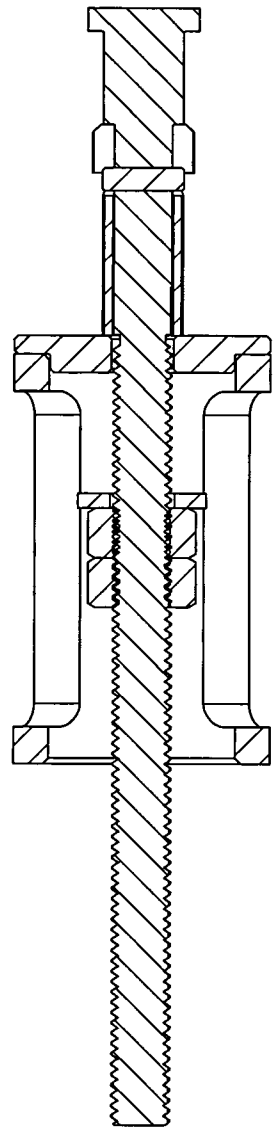
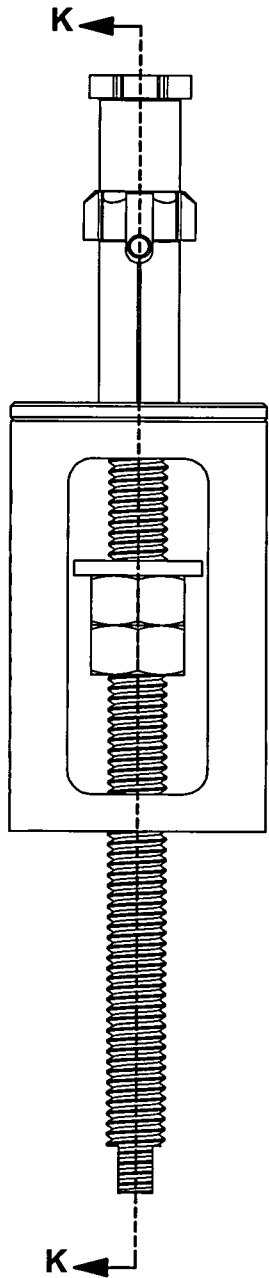
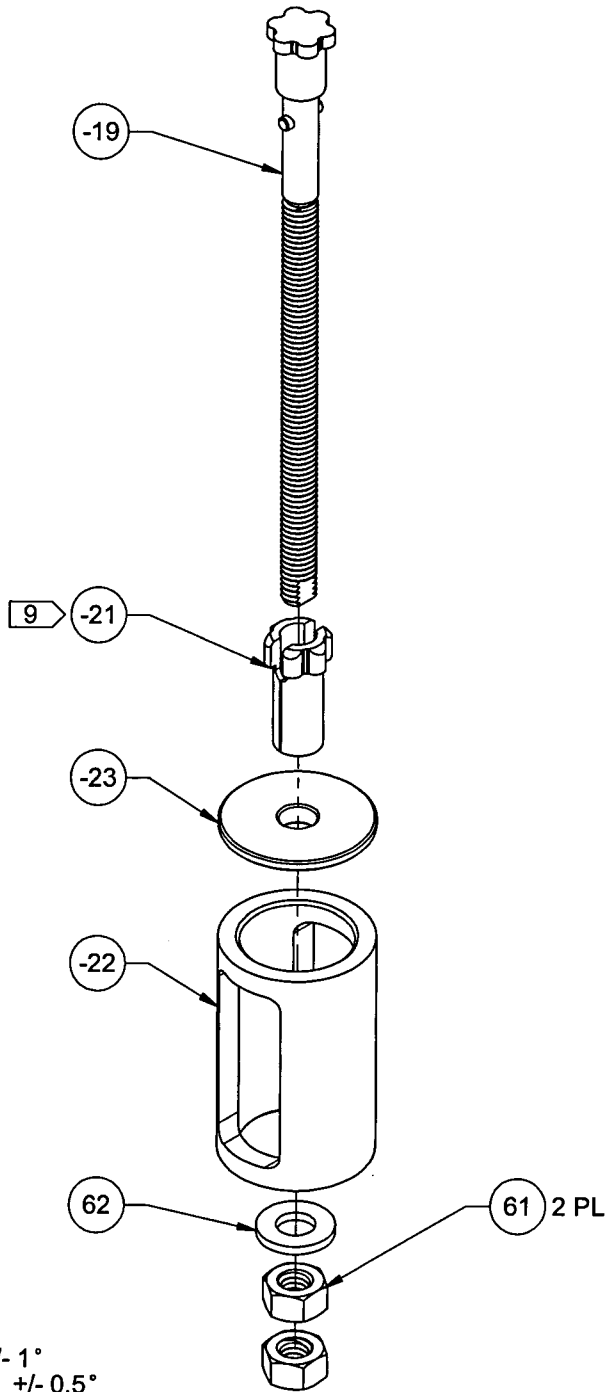
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 17 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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NOTES:
1) MATERIAL: 4140/4142
2) HEAT TREAT: 35-38 Rc
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 18 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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ITEM #	QTY	PART #	PART TITLE
-19	1	RB 92700-10753-042-19	PIN ASSY
-21	1	RB 92700-10753-042-21	SLEEVE
-22	1	RB 92700-10753-042-22	GUIDE
-23	1	RB 92700-10753-042-23	CAP
61	2	McMaster#94895A030 OR EQUIV	STEEL HEX NUT 5/16"-18
62	1	McMaster#98023A030 OR EQUIV.	STEEL WASHER 0.344" ID X 0.688" OD.



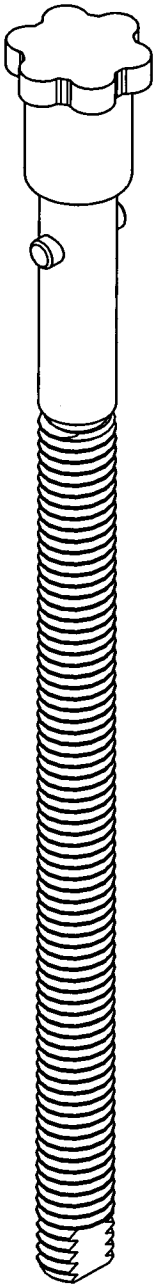
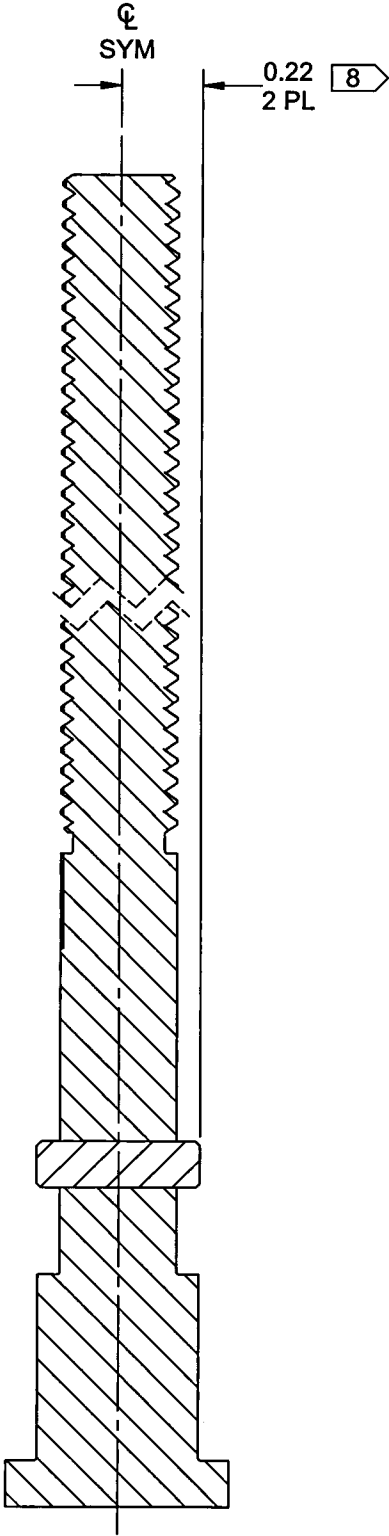
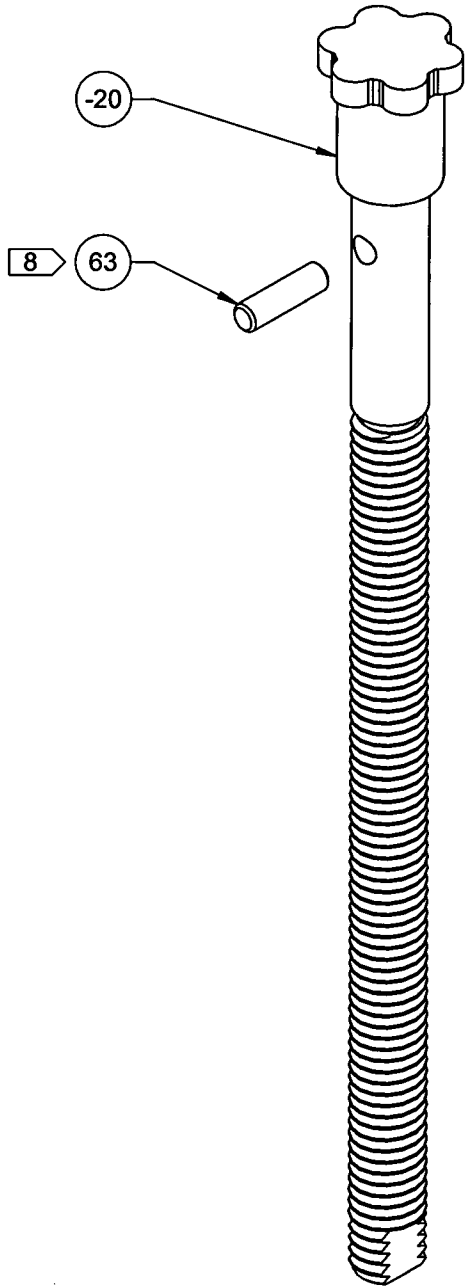
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN
9) SLOT OF ITEM -21 MUST ALIGN WITH DOWEL PIN OF ITEM -19
10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RB 92700-10753-042-18 APU SPLINE REMOVAL TOOL

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 19 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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ITEM #	QTY	PART #	PART TITLE
-20	1	RB 92700-10753-042-20	PIN
63	1	McMaster#98381A218 OR EQUIV	STEEL DOWEL PIN 1/8" DIA. x 7/16" LG.

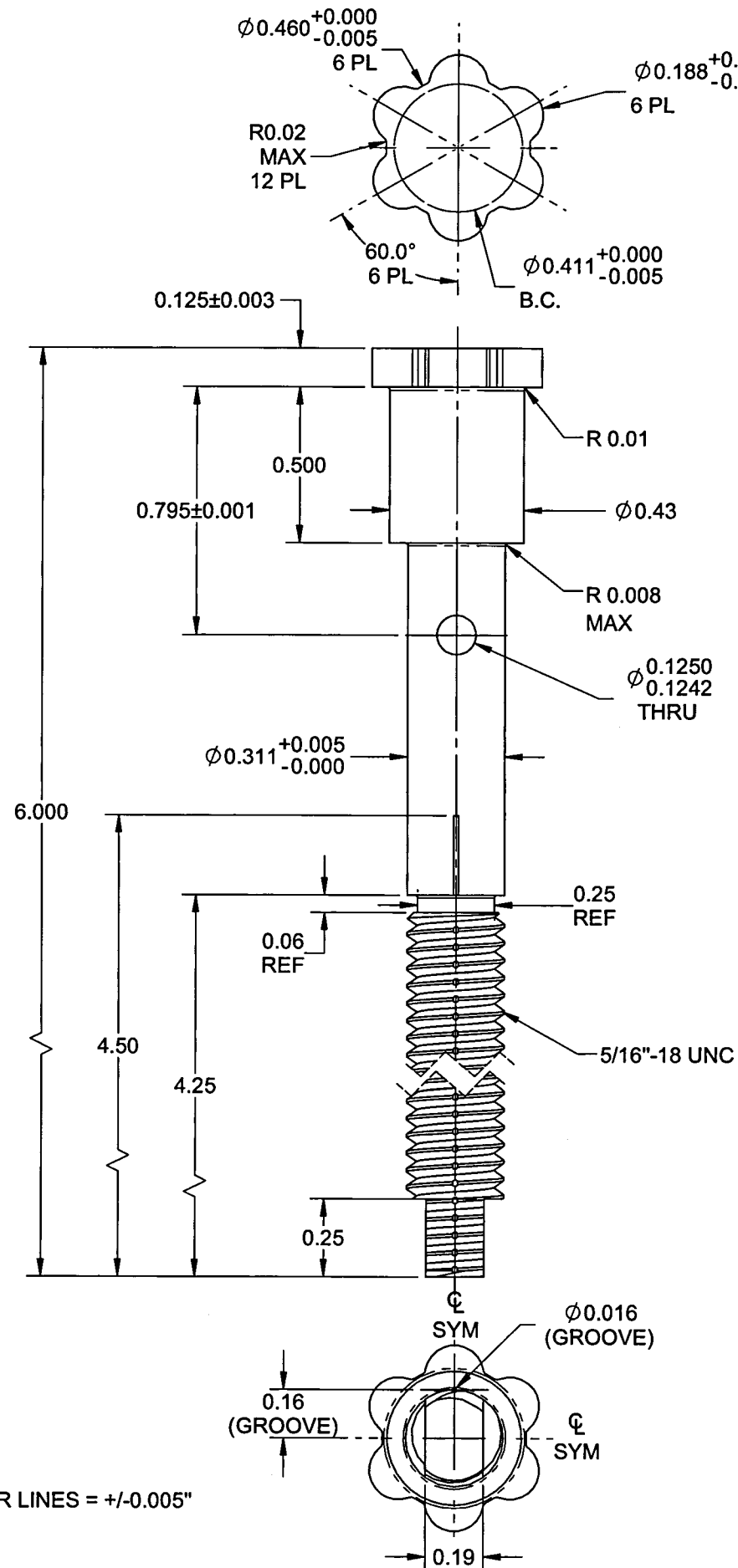


RB 92700-10753-042-19 PIN ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 63 CENTERED WITH ITEM -20 AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 20 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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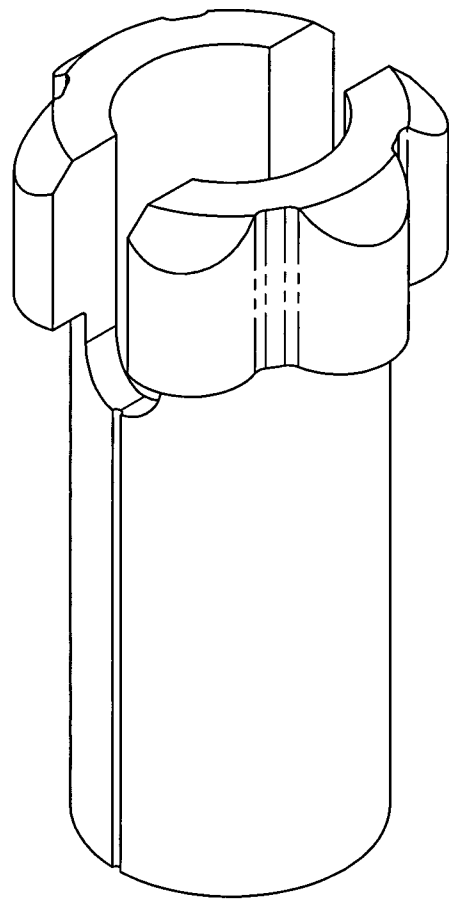
RB 92700-10753-042-20 PIN



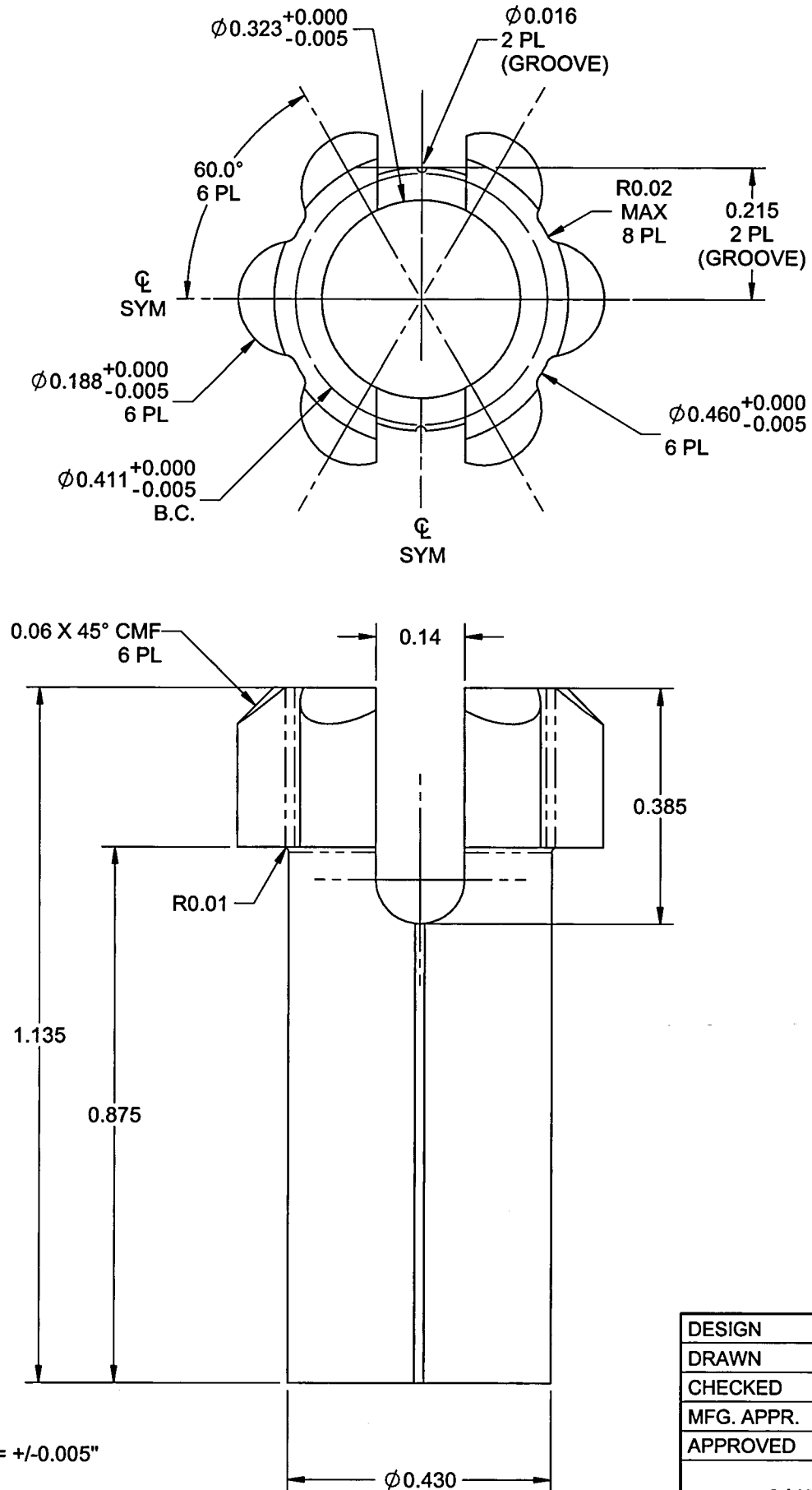
NOTES:

- 1) MATERIAL: 4140/4142
- 2) HEAT TREAT: 35-38 Rc
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 21 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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RB 92700-10753-042-21 SLEEVE

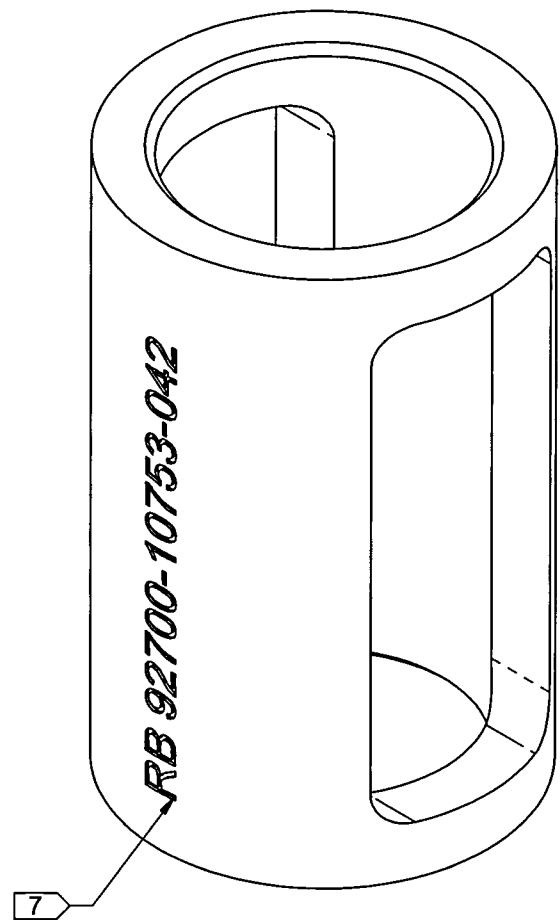


NOTES:

- 1) MATERIAL: 4140/4142
- 2) HEAT TREAT: 35-38 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

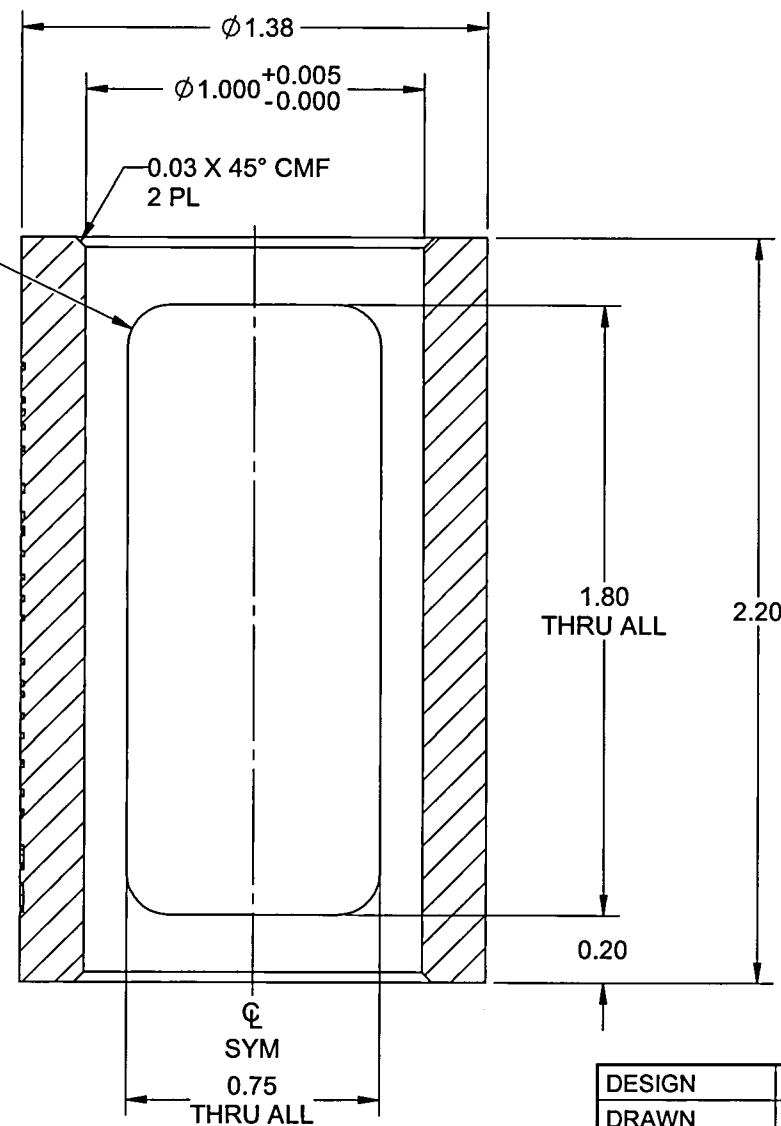
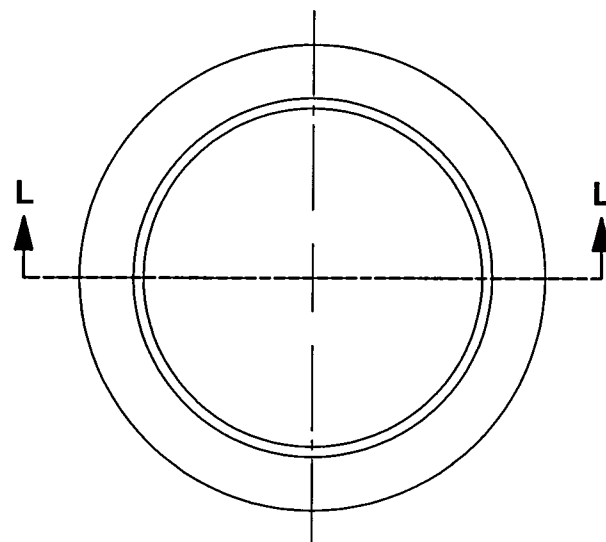
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 22 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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RB 92700-10753-042-22 GUIDE

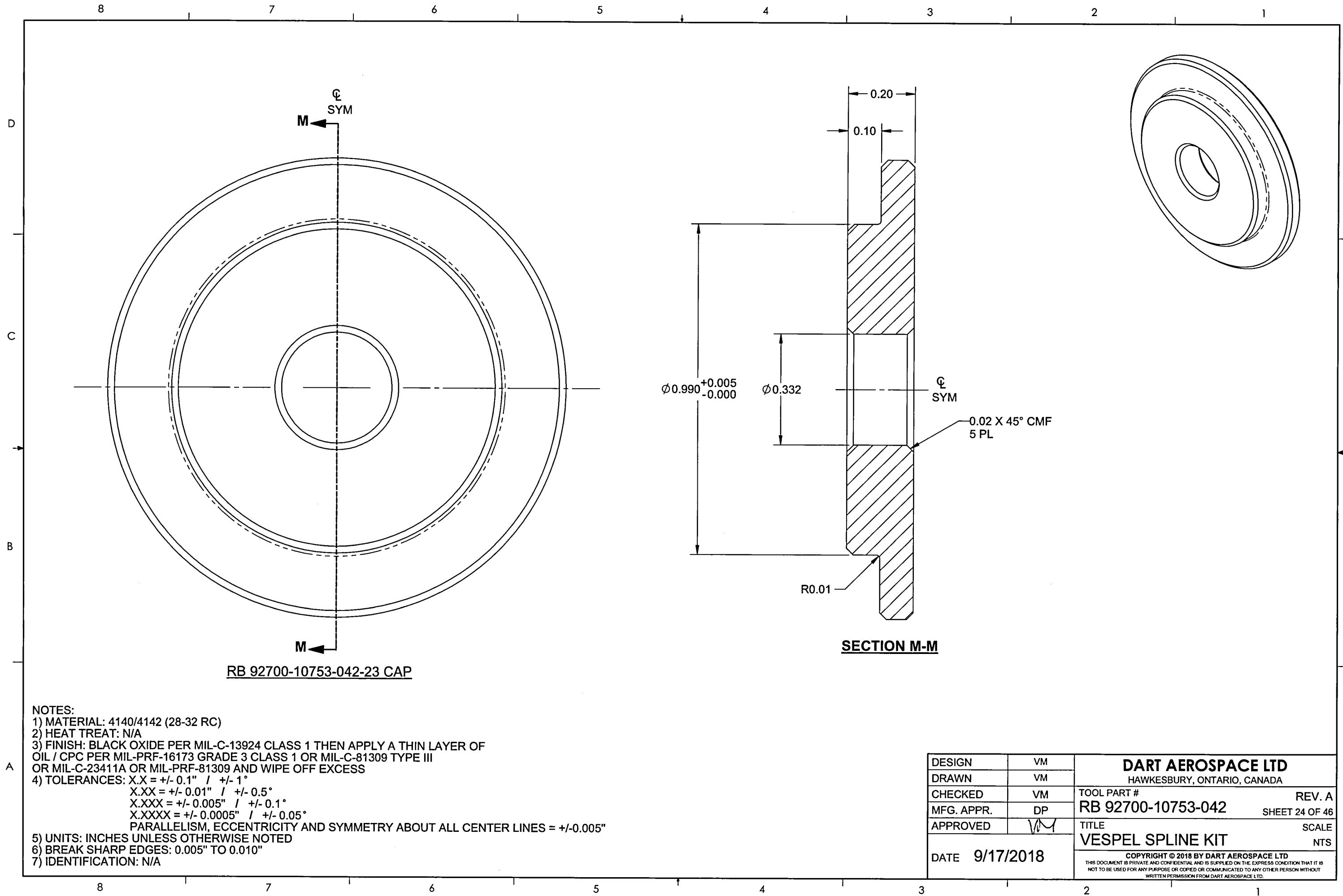
R0.13
8 PL



NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

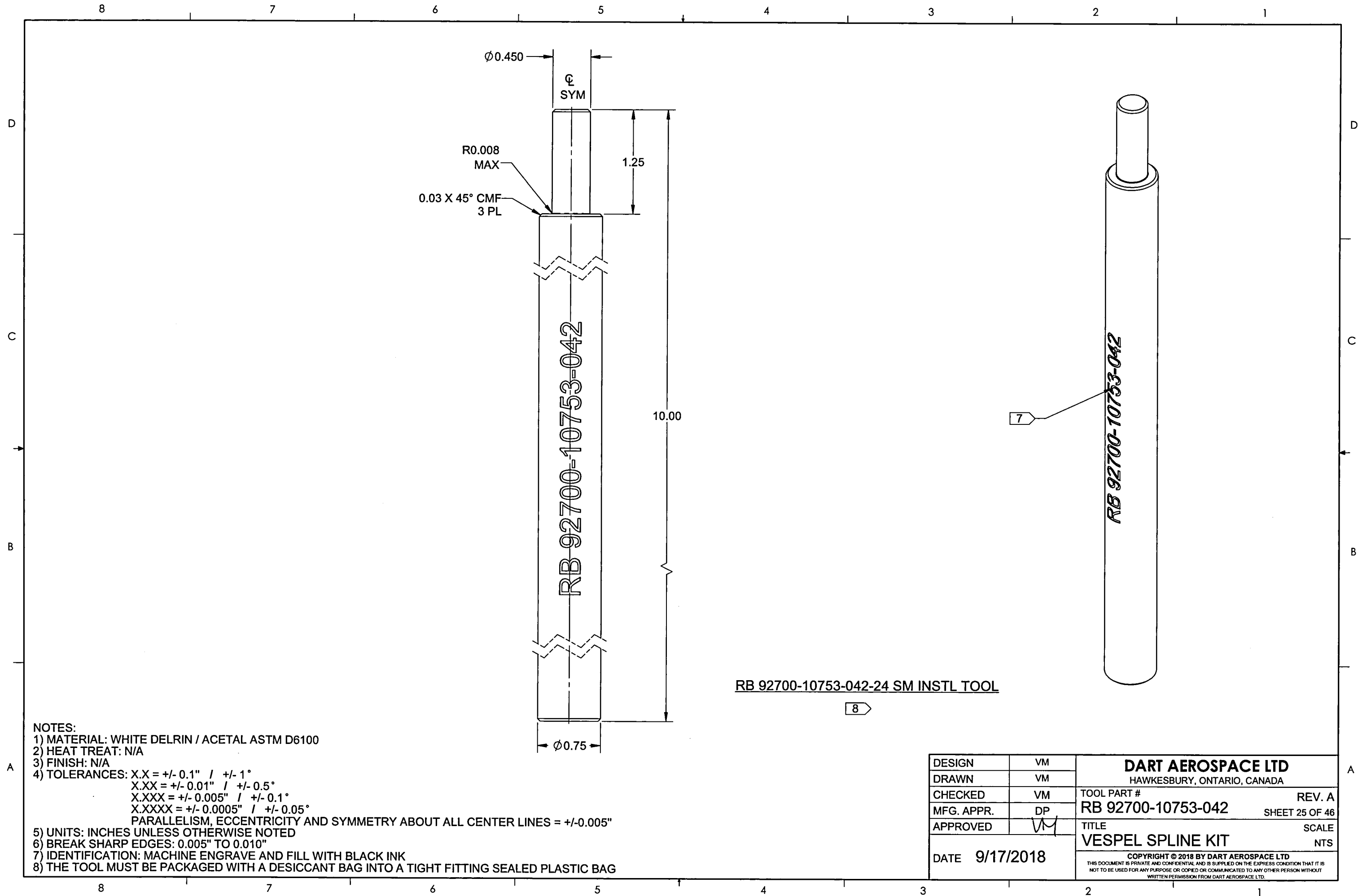
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 23 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VEPEL SPLINE KIT	NTS
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NOTES:

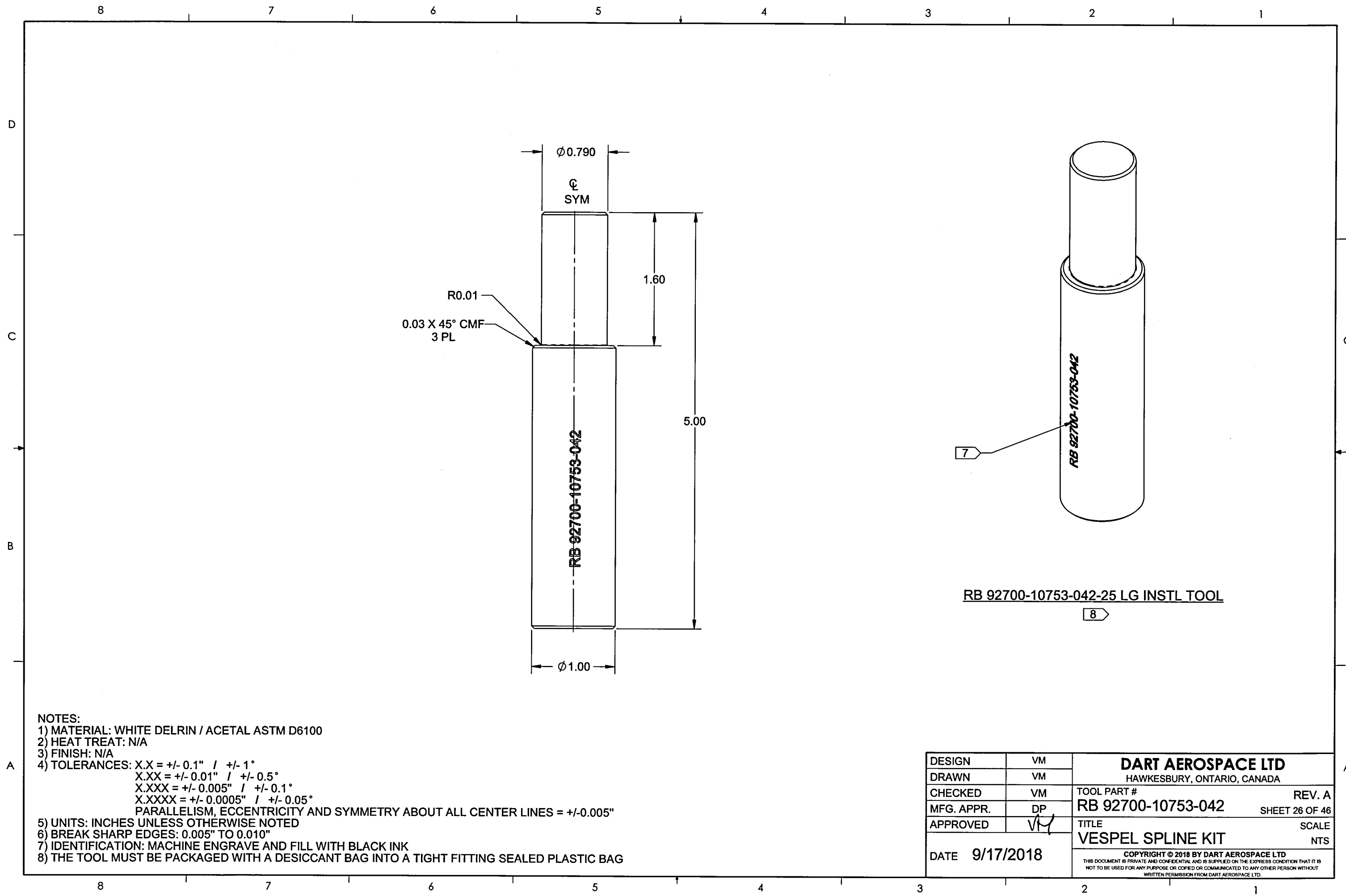
- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 24 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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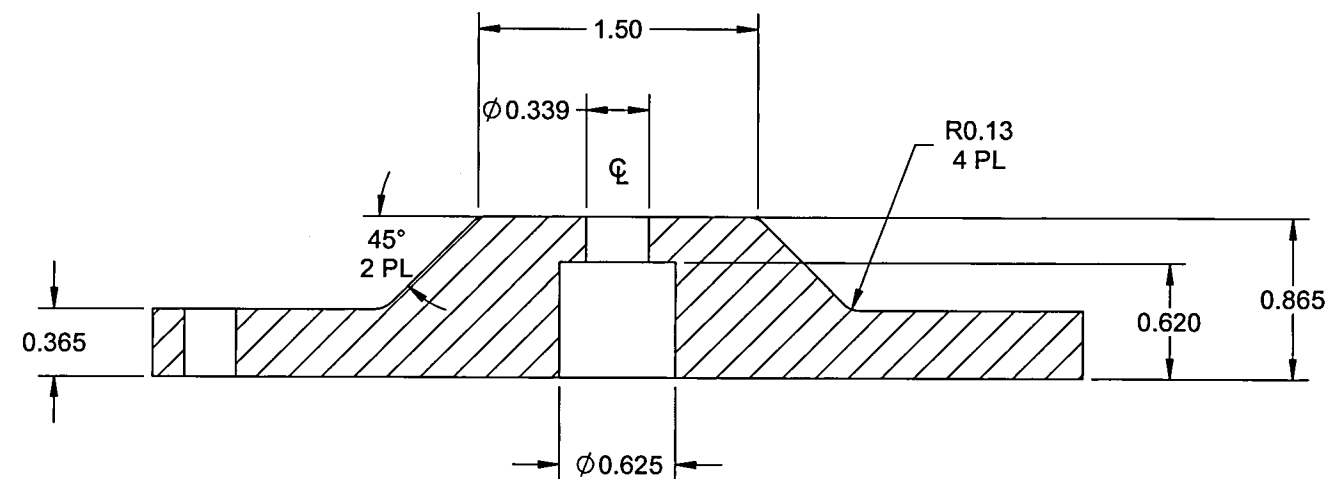
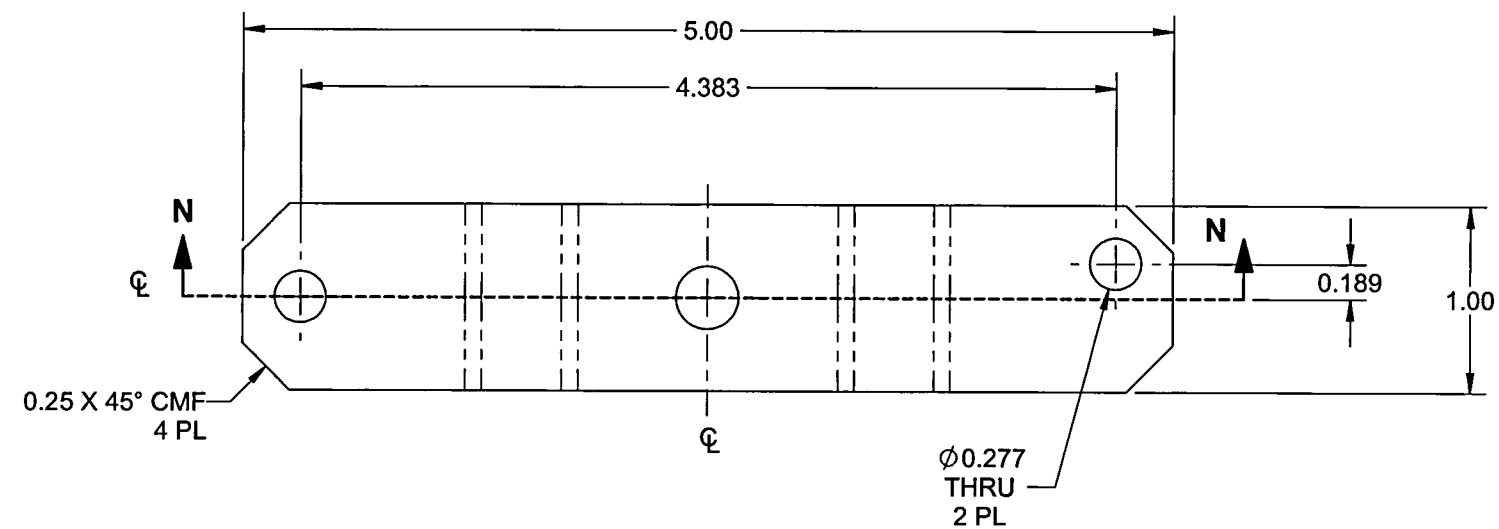
NOTES:
1) MATERIAL: WHITE DELRIN / ACETAL ASTM D6100
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE AND FILL WITH BLACK INK
8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 25 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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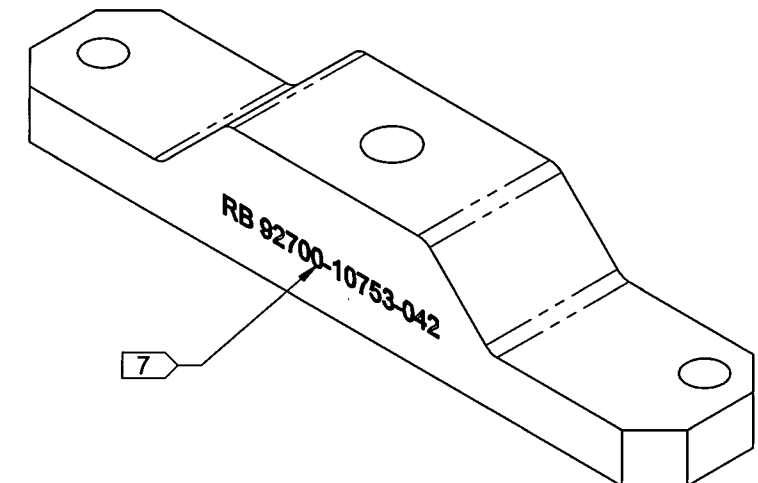


- NOTES:
- 1) MATERIAL: WHITE DELRIN / ACETAL ASTM D6100
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE AND FILL WITH BLACK INK
 - 8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 26 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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SECTION N-N



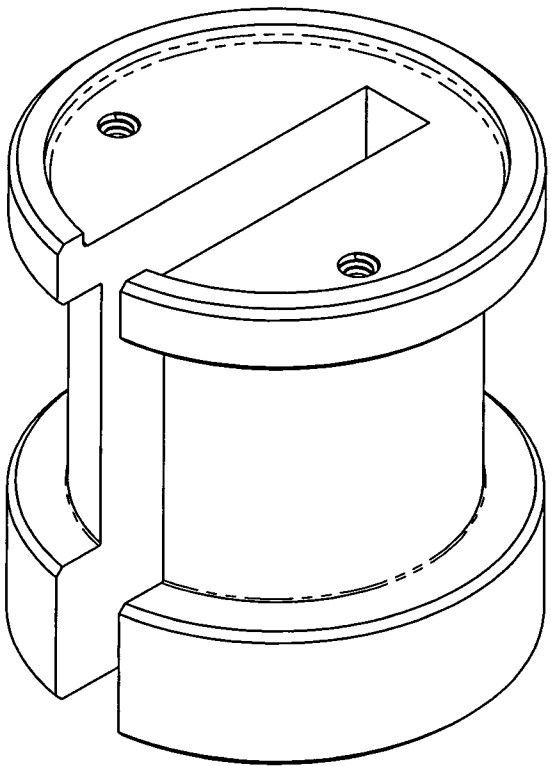
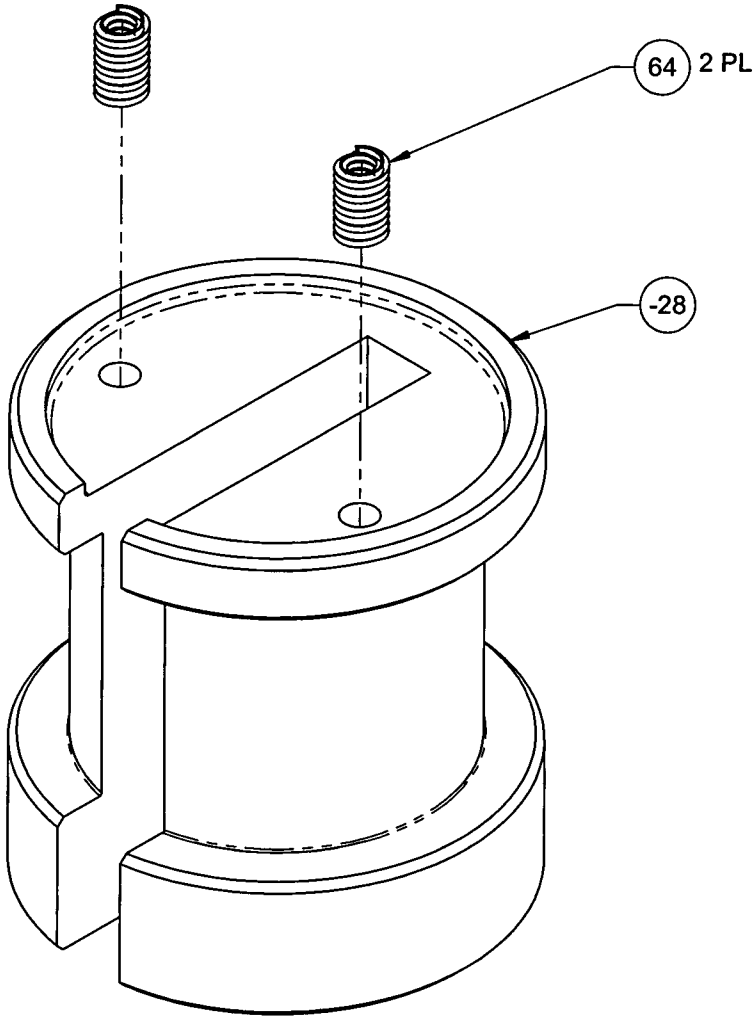
RB 92700-10753-042-26 LUBE PUMP BRIDGE

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN
- 8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 27 OF 46
APPROVED	✓	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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ITEM #	QTY	PART #	PART TITLE
-28	1	RB 92700-10753-042-28	GUIDE
64	2	McMaster#91732A708 OR EQUIV	SS THREADED INSERT #6-32 x 0.345" LG

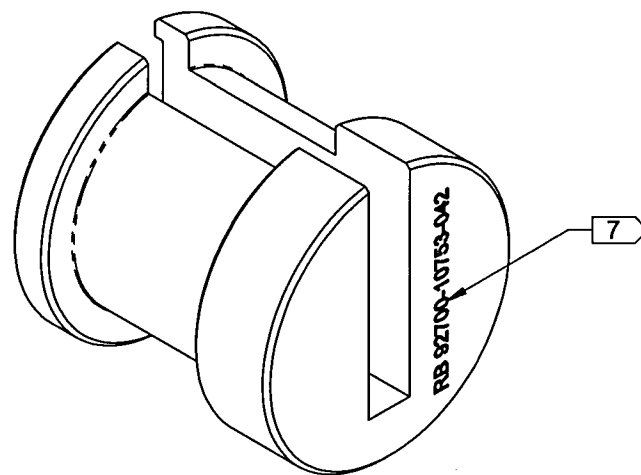
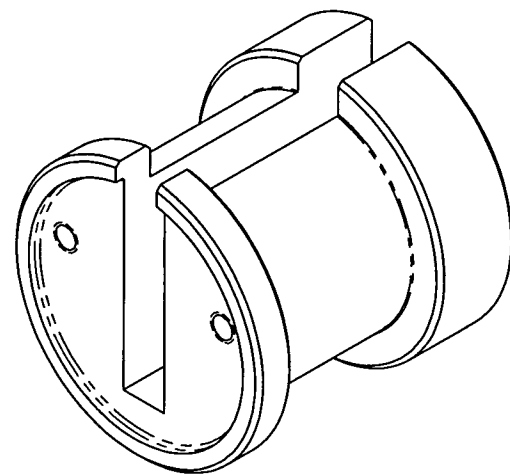


- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

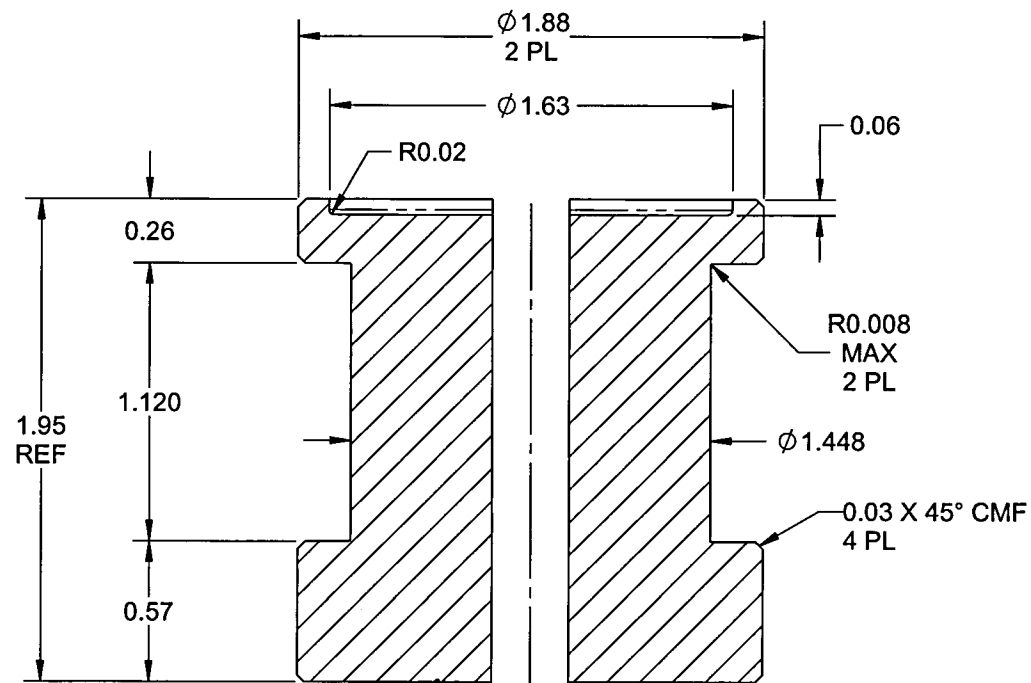
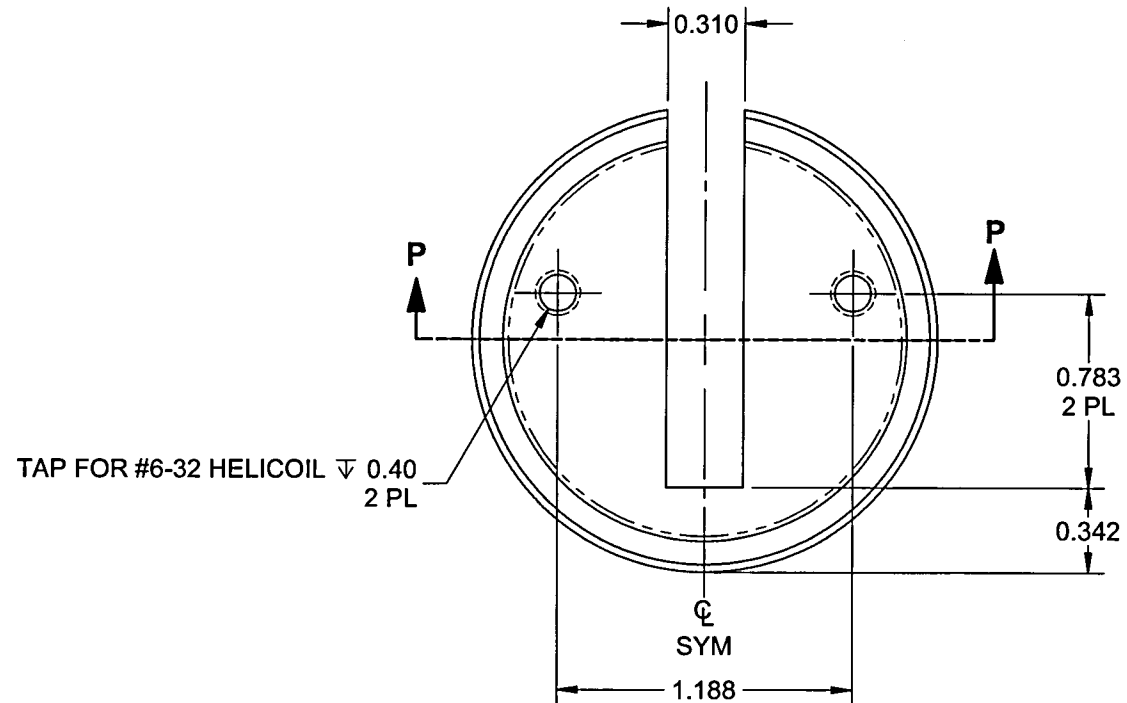
RB 92700-10753-042-27 SMALL GUIDE

9

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 28 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VEPEL SPLINE KIT	NTS
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RB 92700-10753-042-28 GUIDE



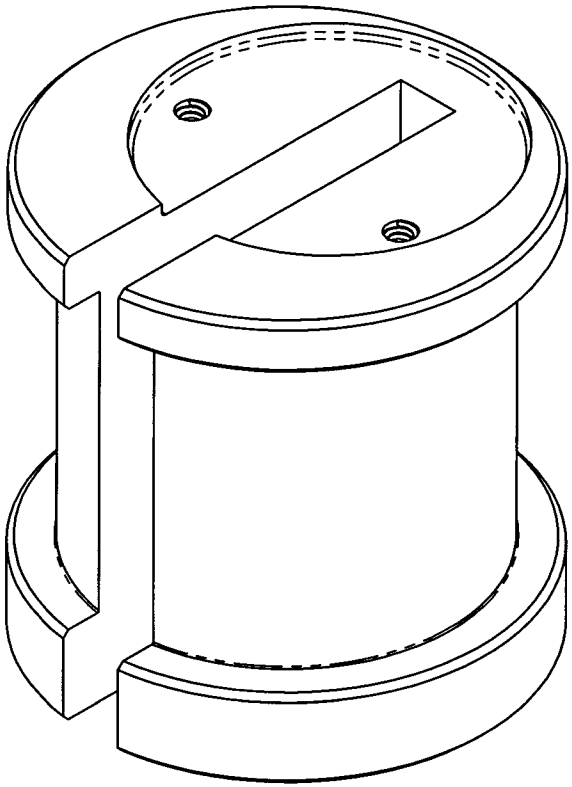
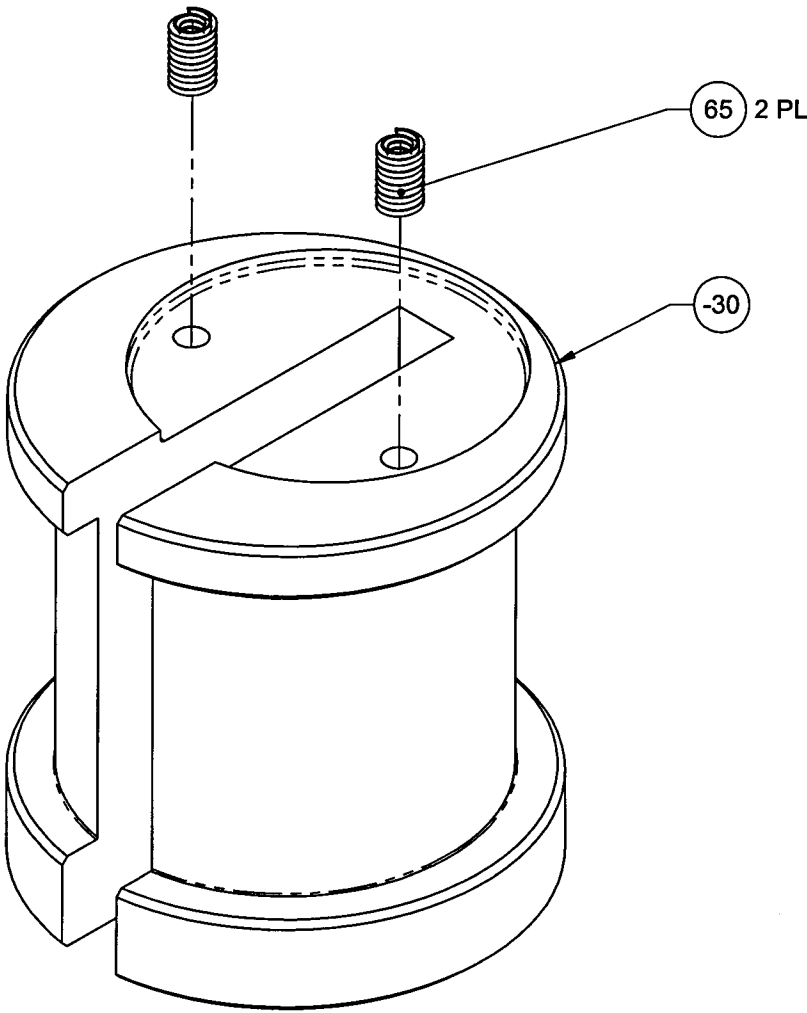
SECTION P-P

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 29 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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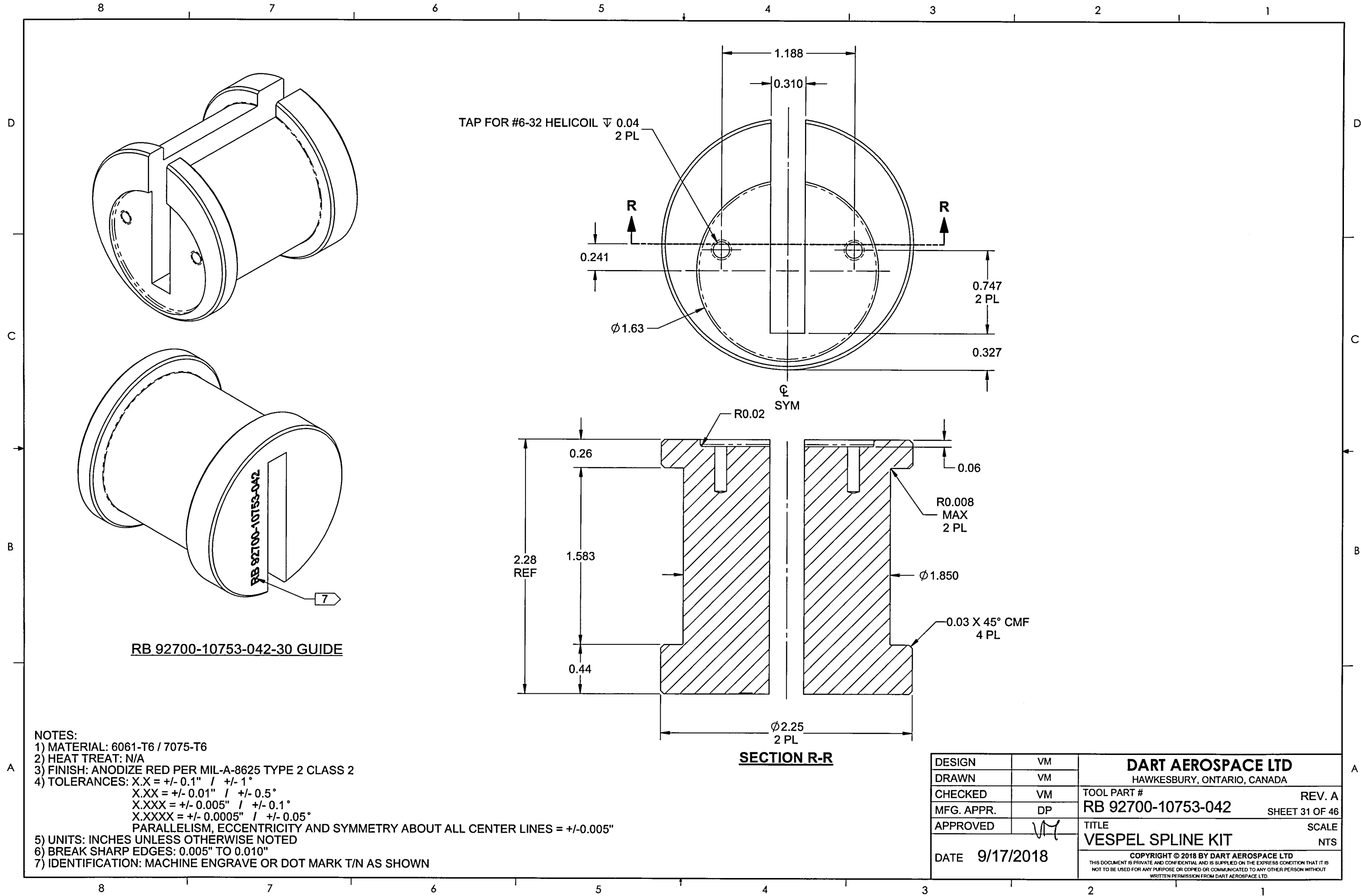
ITEM #	QTY	PART #	PART TITLE
-30	1	RB 92700-10753-042-30	GUIDE
65	2	McMaster#91732A708 OR EQUIV	SS THREADED INSERT #6-32 x 0.345" LG



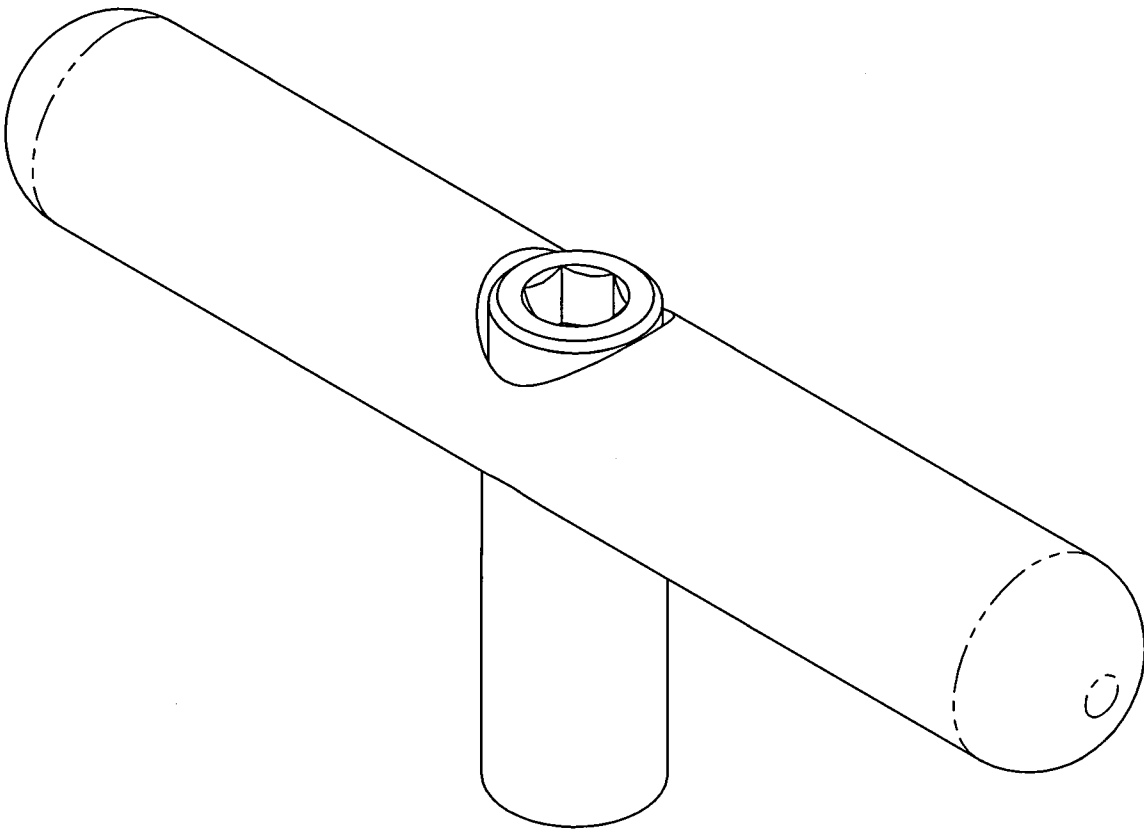
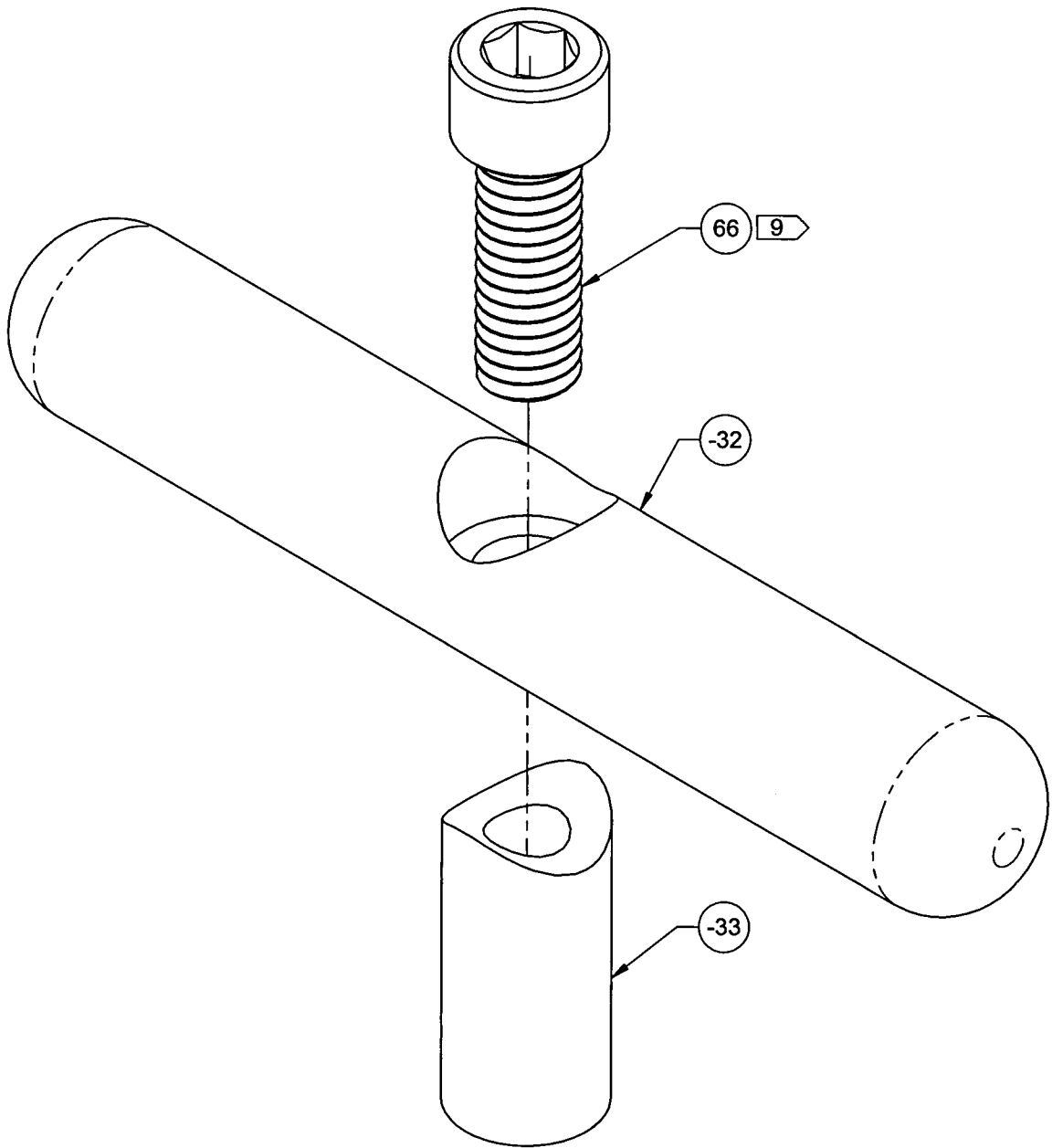
RB 92700-10753-042-29 LARGE GUIDE

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 30 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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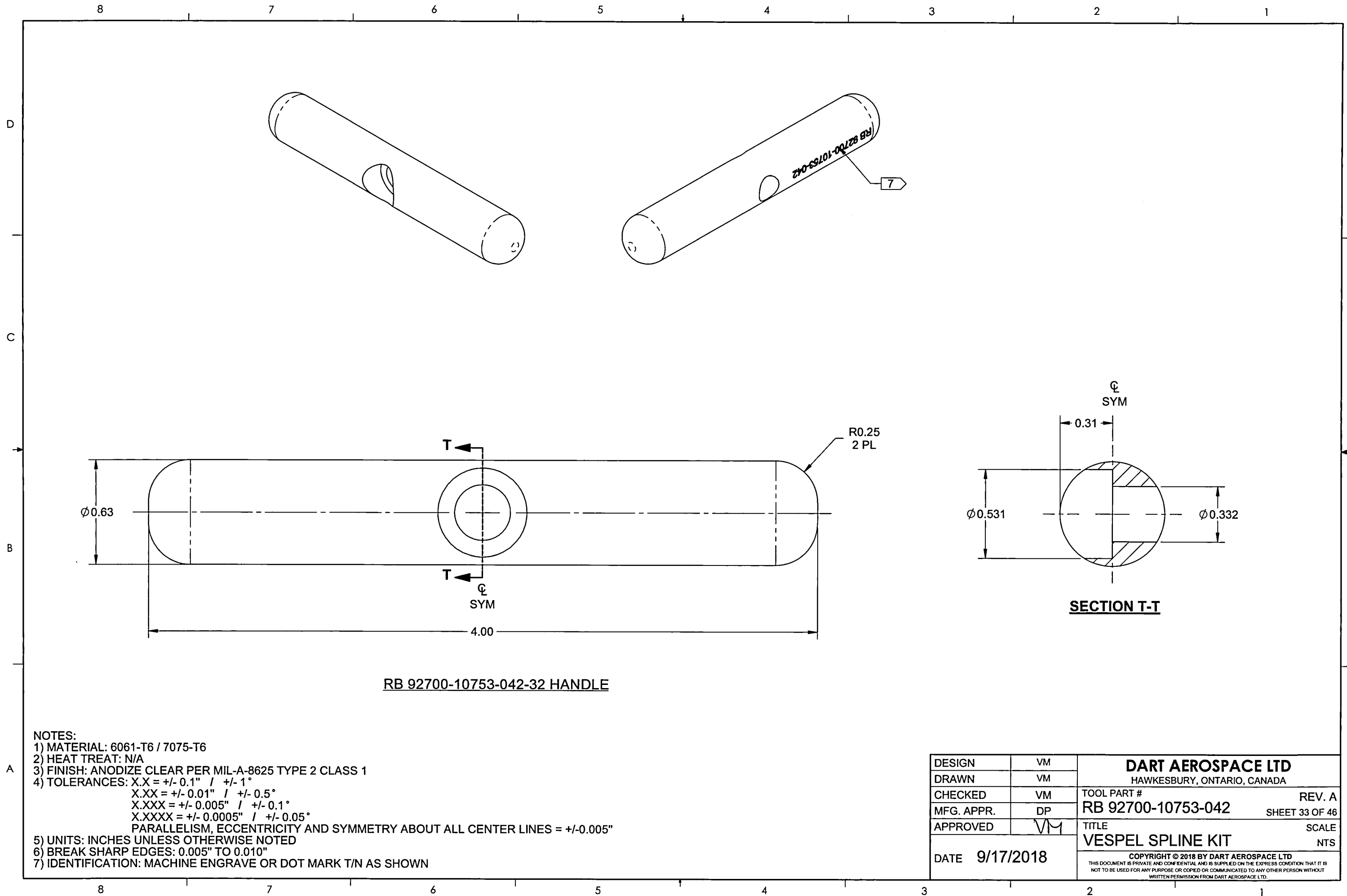
ITEM #	QTY	PART #	PART TITLE
-32	1	RB 92700-10753-042-32	HANDLE
-33	1	RB 92700-10753-042-33	PIN
66	1	McMaster#90128A582 OR EQUIV	STEEL SOCKET HEAD CAP SCREW 5/16"-18 x 7/8" LG.



RB 92700-10753-042-31 HANDLE ASSEMBLY

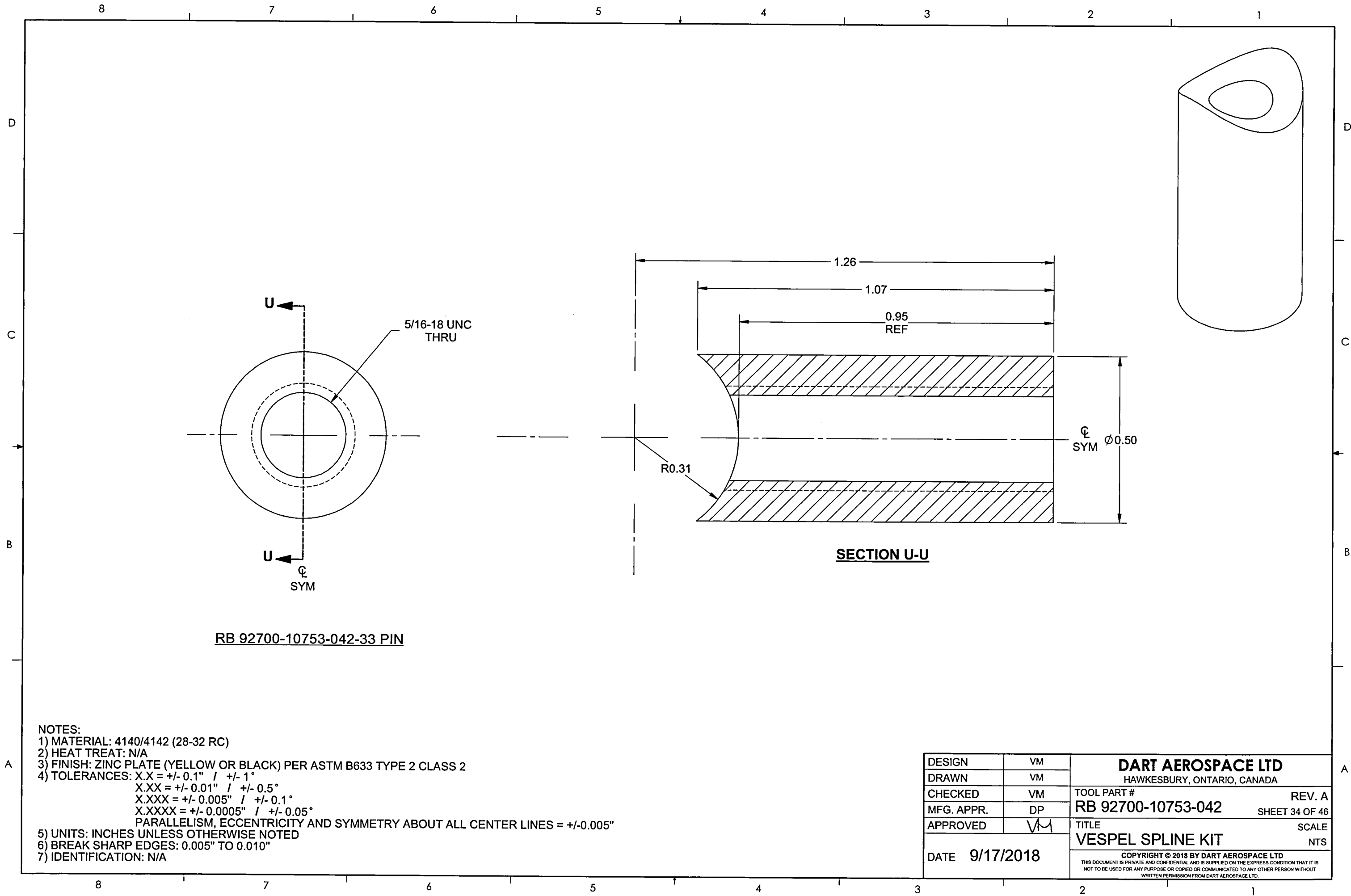
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 66 THEN ASSEMBLE WITH ITEM -33 HAND TIGHT AND REMOVE EXCESS
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

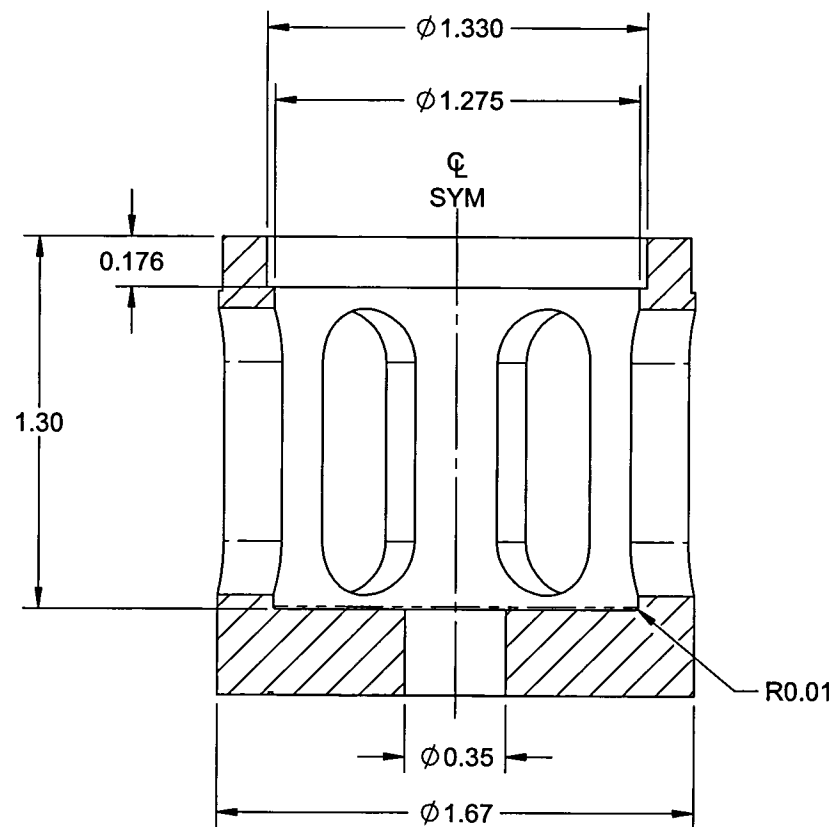
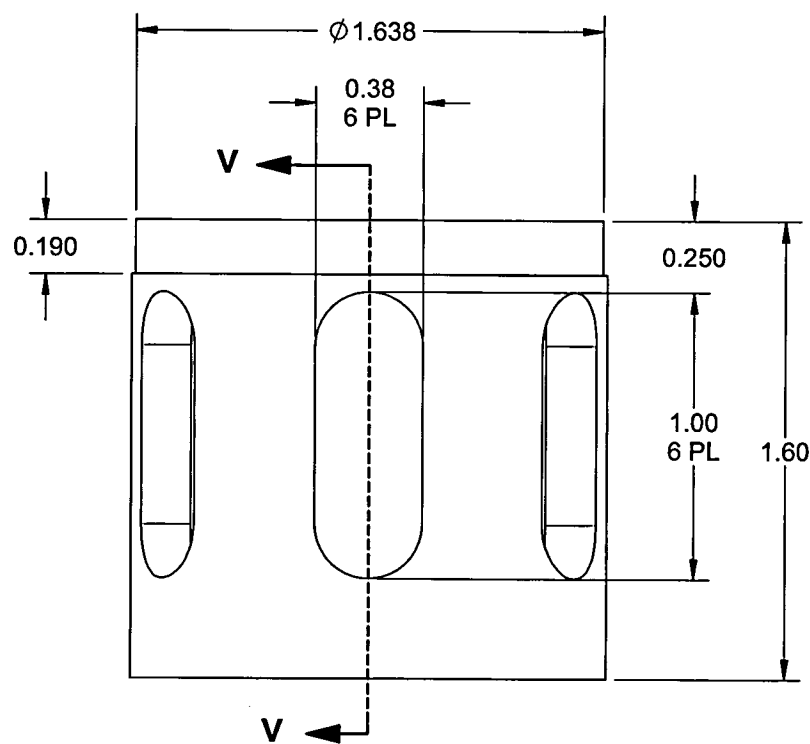
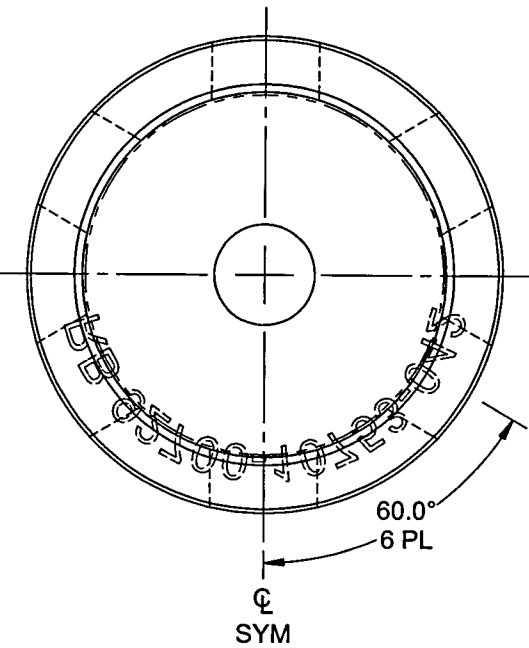
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 32 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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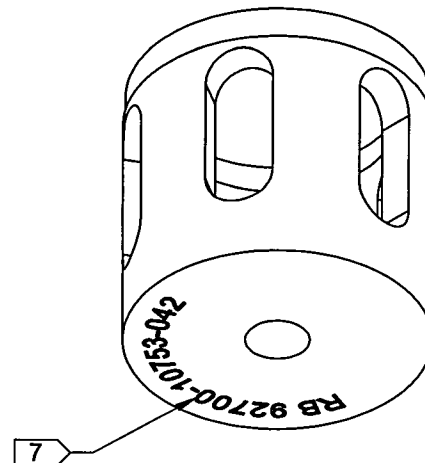
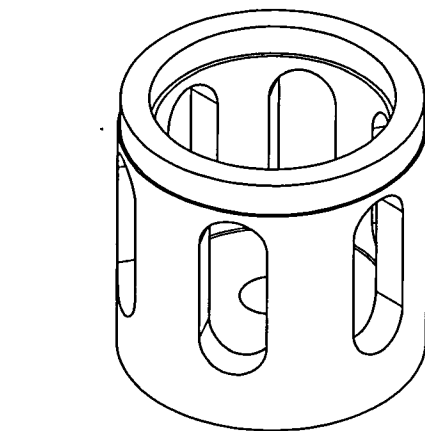
NOTES:
1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE CLEAR PER MIL-A-8625 TYPE 2 CLASS 1
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 33 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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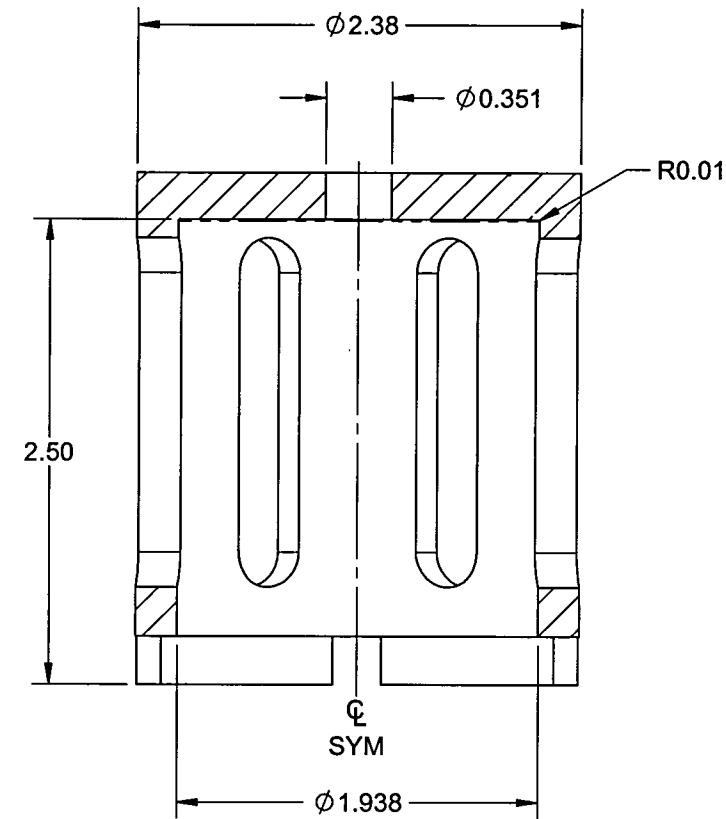
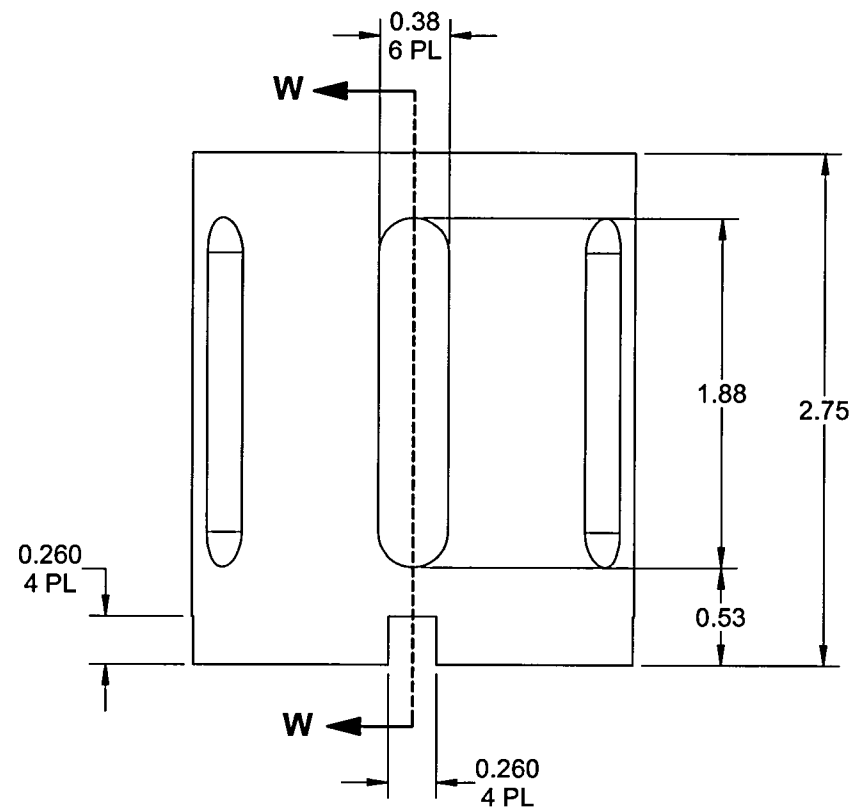
SECTION V-V



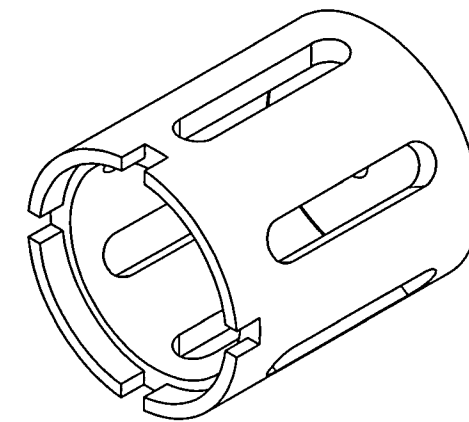
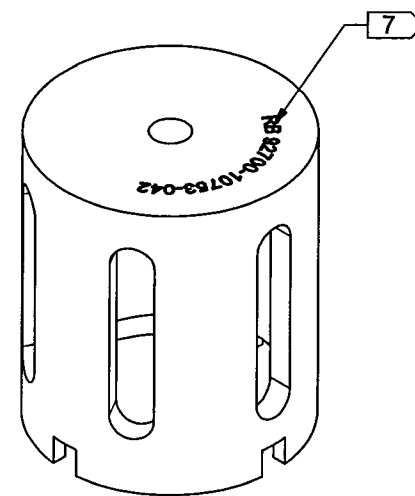
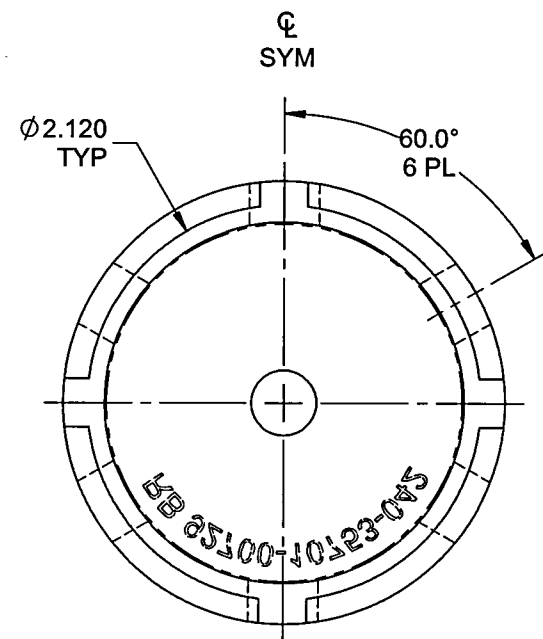
RB 92700-10753-042-34 SMALL TUBE

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
 - 8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 35 OF 46
APPROVED	WY	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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SECTION W-W

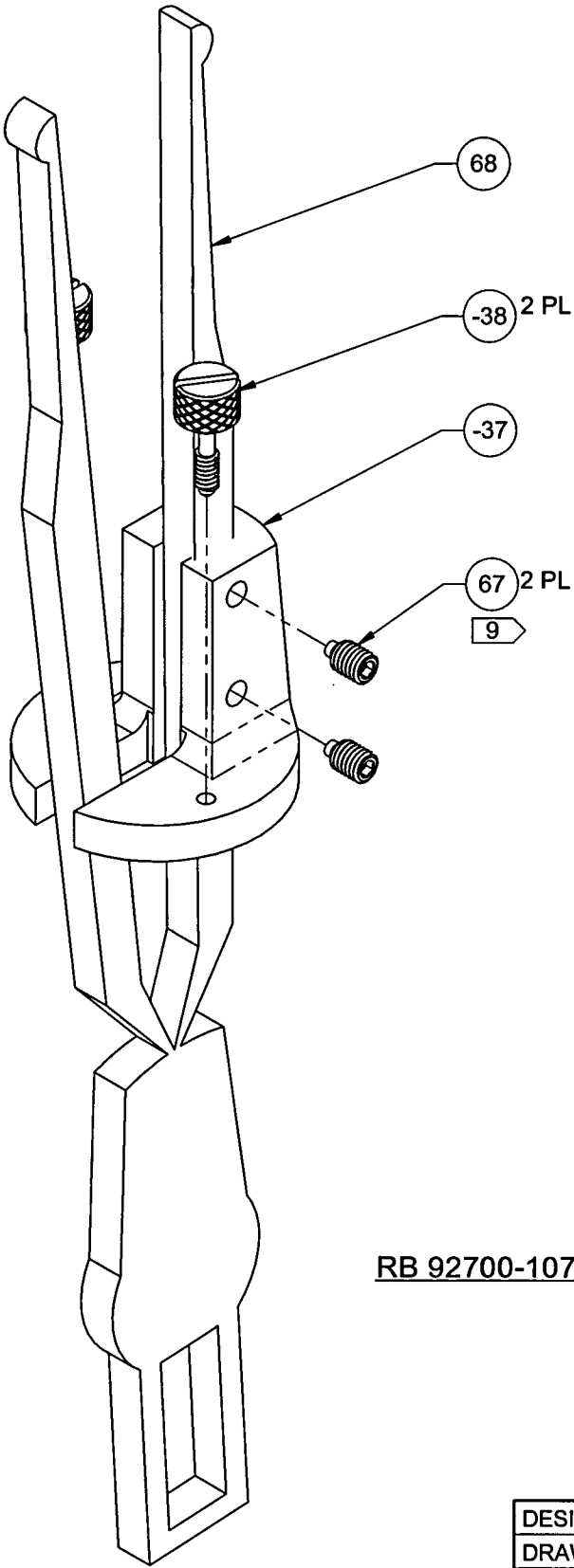
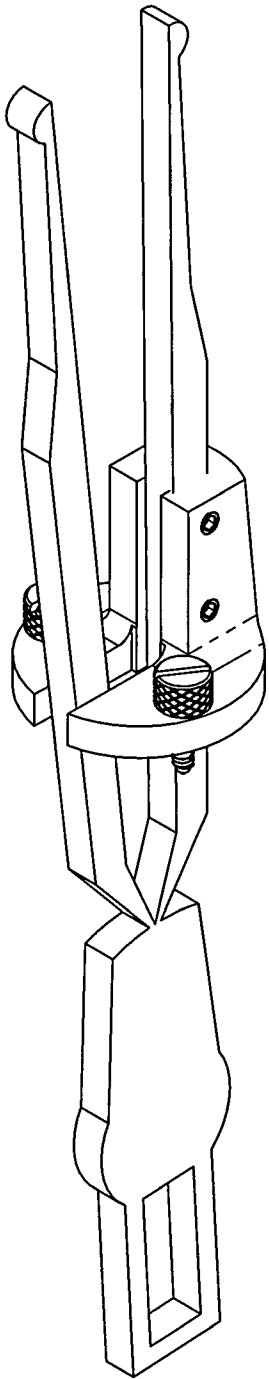


RB 92700-10753-042-35 LARGE TUBE

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
 - 8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 36 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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ITEM #	QTY	PART #	PART TITLE
-37	1	RB 92700-10753-042-37	BLOCK
-38	2	RB 92700-10753-042-38	THUMB SCREW MODIFIED
67	2	McMaster#90291A825 OR EQUIV	SS NYLON TIP SET SCREW #10-32 x 1/4" LG.
68	1	DYER#101-105-16525	CUSTOM MADE MICROMETER

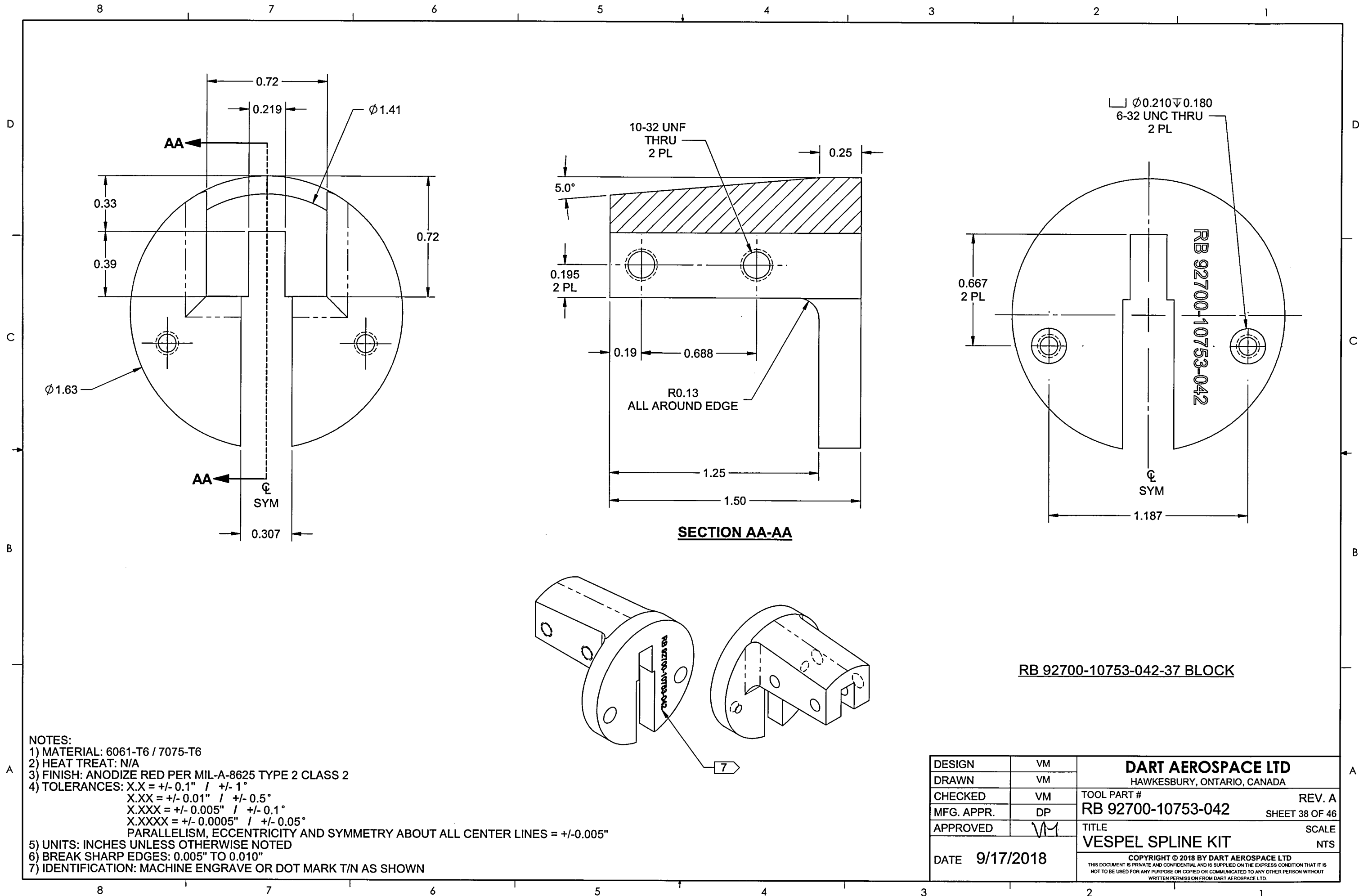


RB 92700-10753-042-36 GAGE ASSEMBLY

10

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN
9) INSTALL ITEMS 67 HAND TIGHT
10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

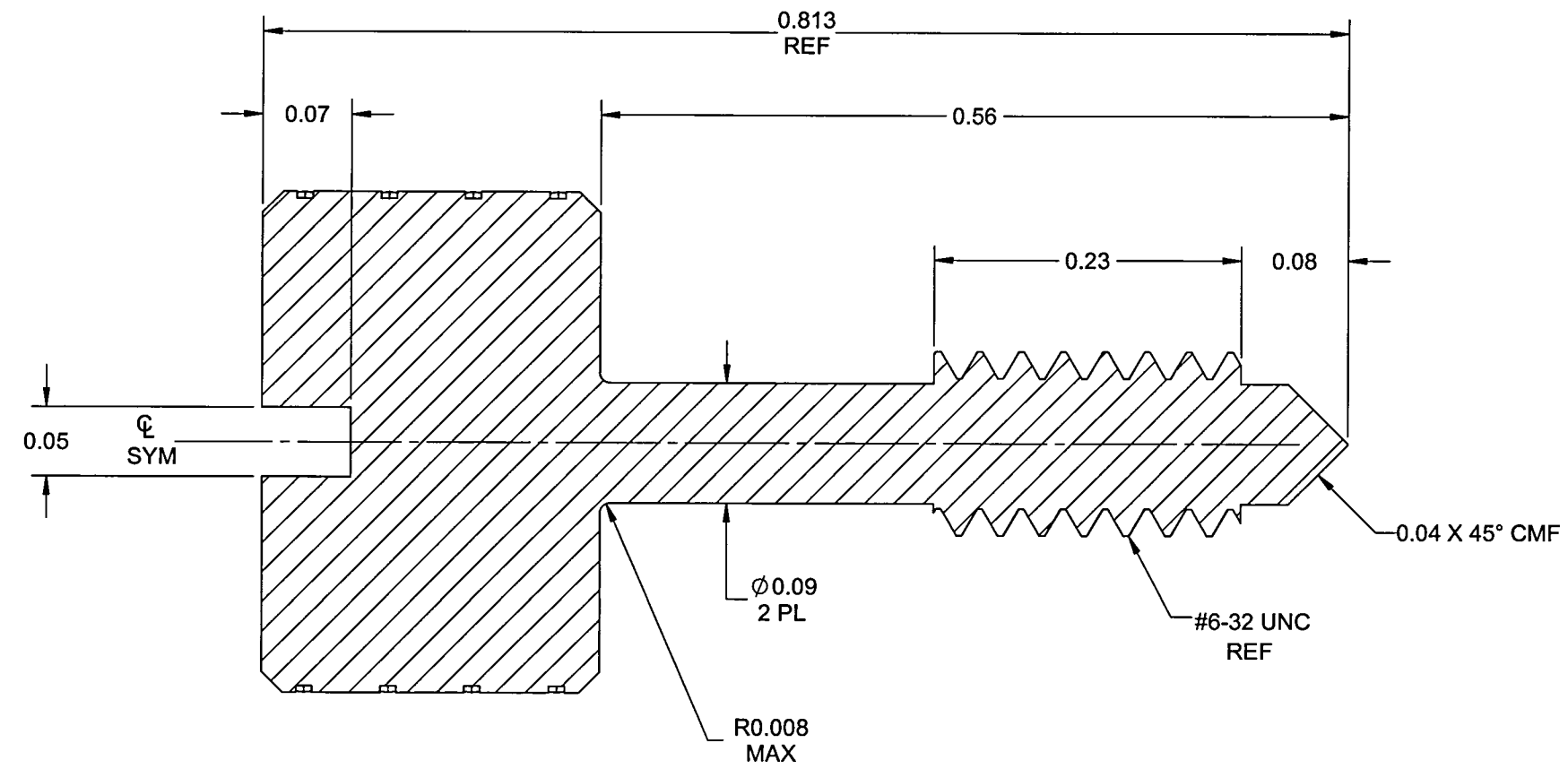
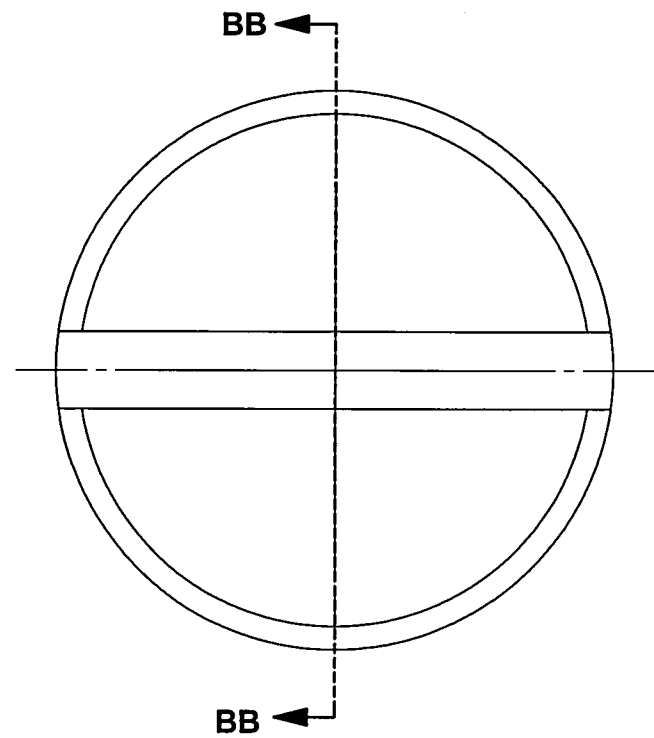
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 37 OF 46
APPROVED	VP	TITLE	SCALE
DATE 9/17/2018		VEPEL SPLINE KIT	NTS
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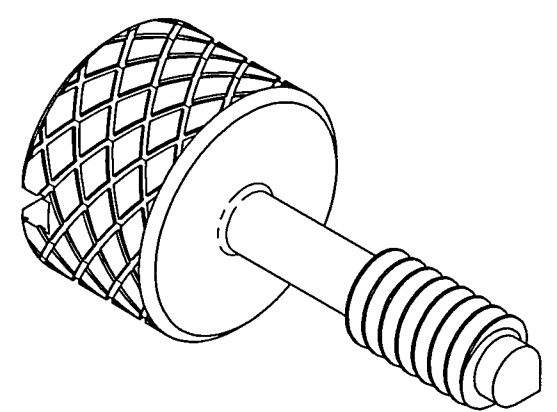
NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 38 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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SECTION BB-BB

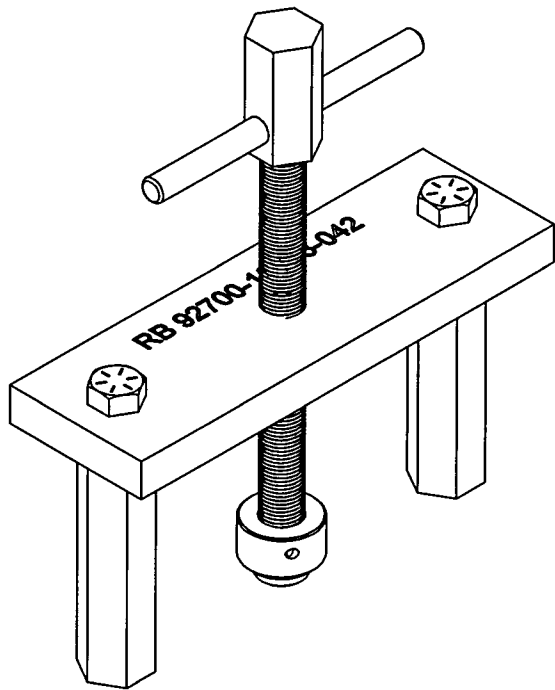
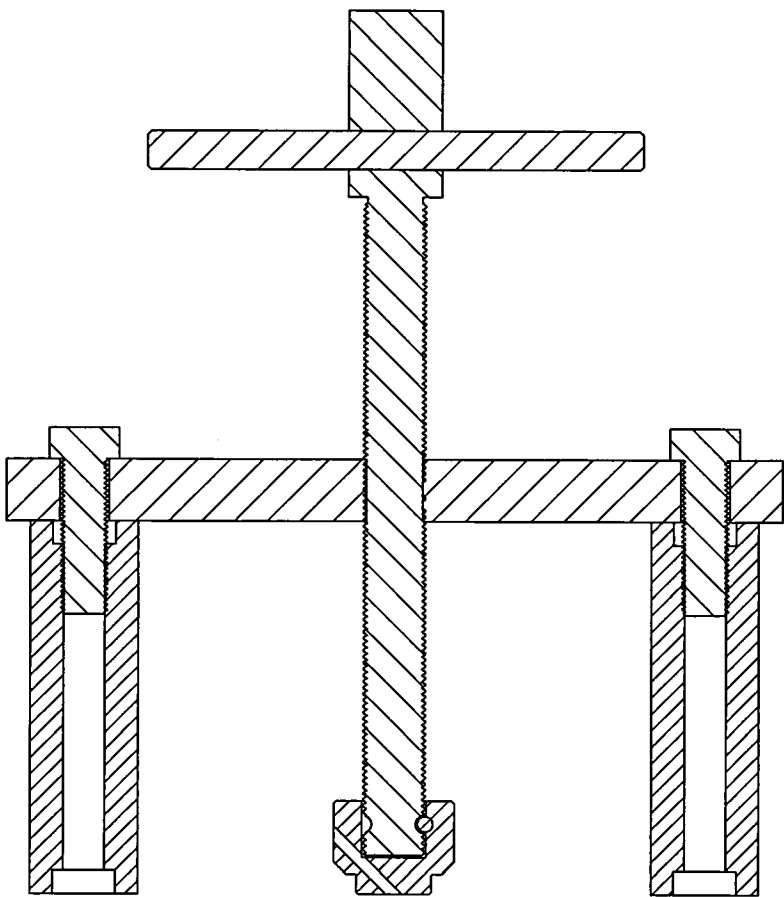
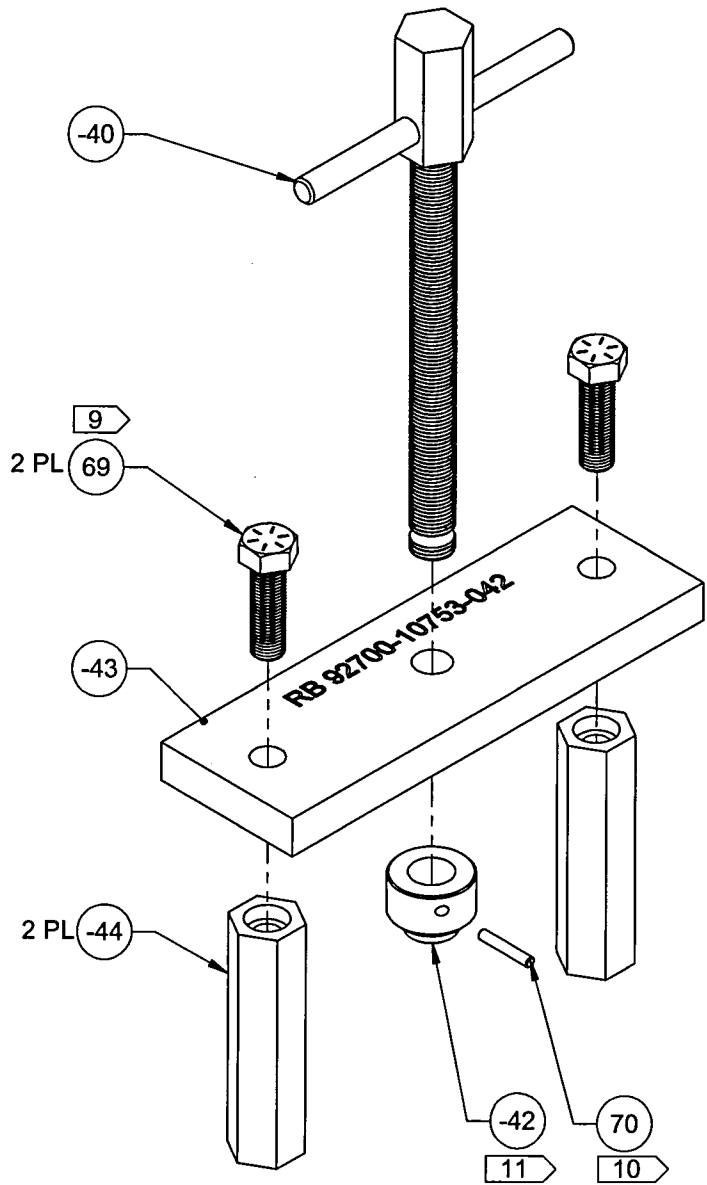


RB 92700-10753-042-38 THUMB SCREW MODIFIED

NOTES:
1) MATERIAL: McMaster#93585A015 OR EQUIV
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 39 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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ITEM #	QTY	PART #	PART TITLE
-40	1	RB 92700-10753-042-40	HANDLE ASSY
-42	1	RB 92700-10753-042-42	PUSHER
-43	1	RB 92700-10753-042-43	BASE
-44	2	RB 92700-10753-042-44	LEG
69	2	McMaster#92620A656 OR EQUIV	STEEL HEX HEAD SCREW 3/8"-24 x 1-1/4" LG.
70	1	McMaster#98381A308 OR EQUIV	STEEL DOWEL PIN 1/8" DIA. x 3/4" LG.



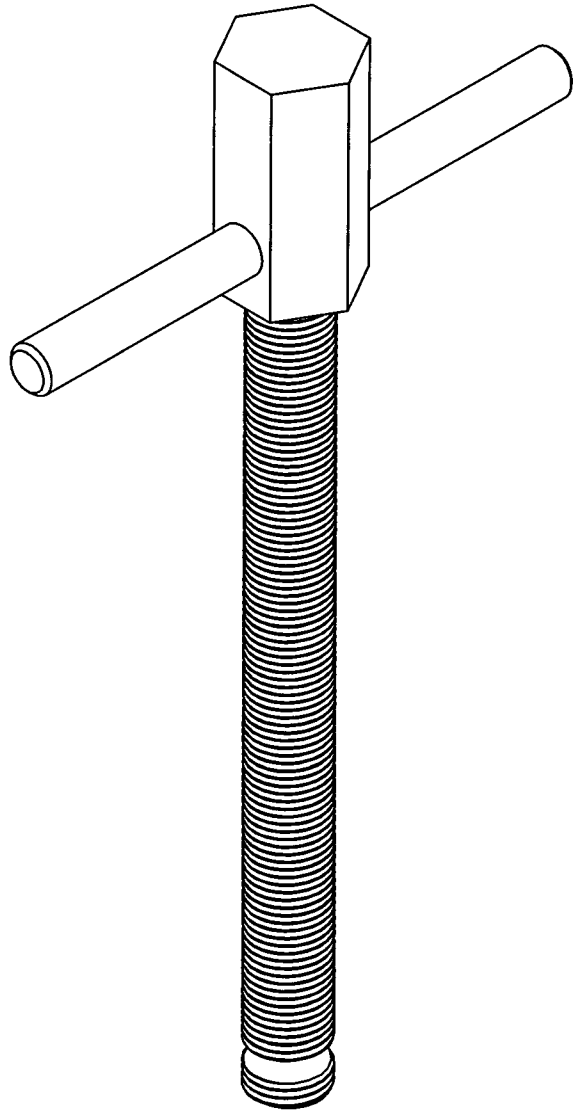
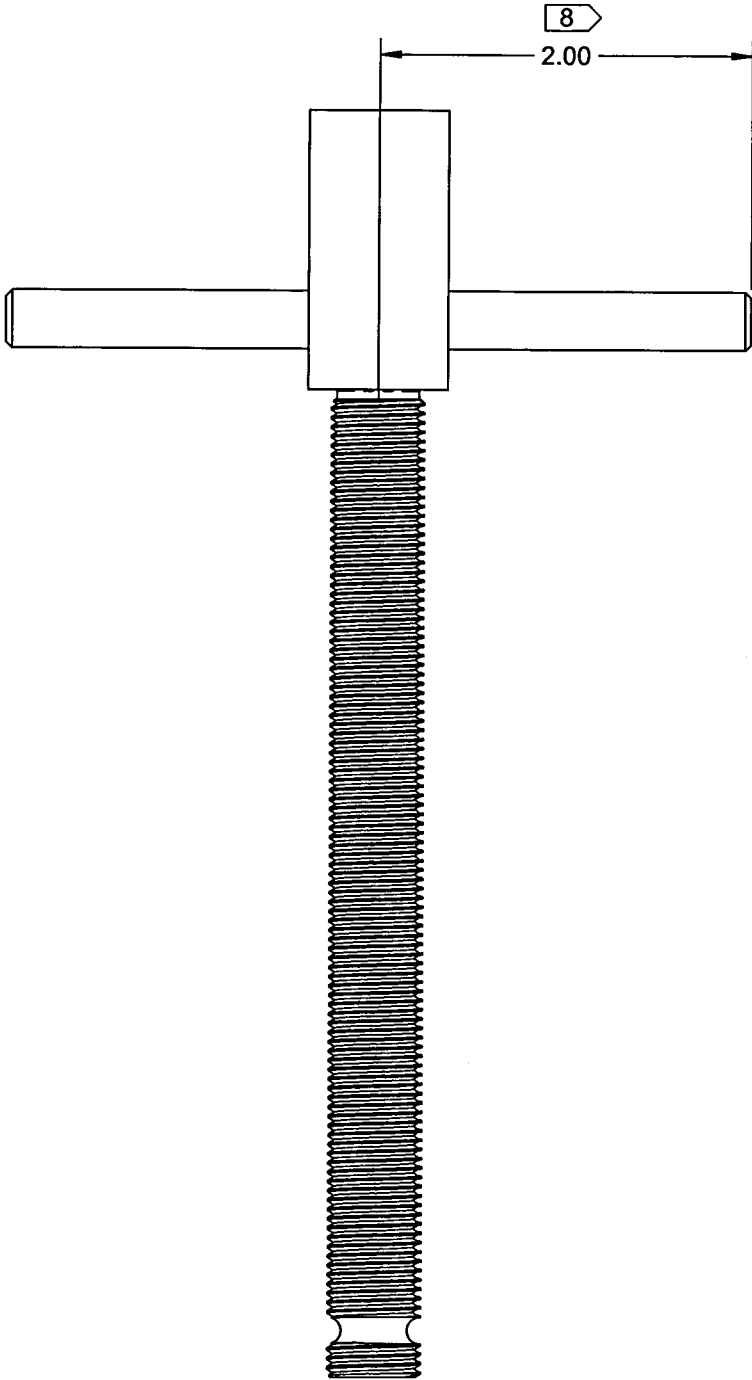
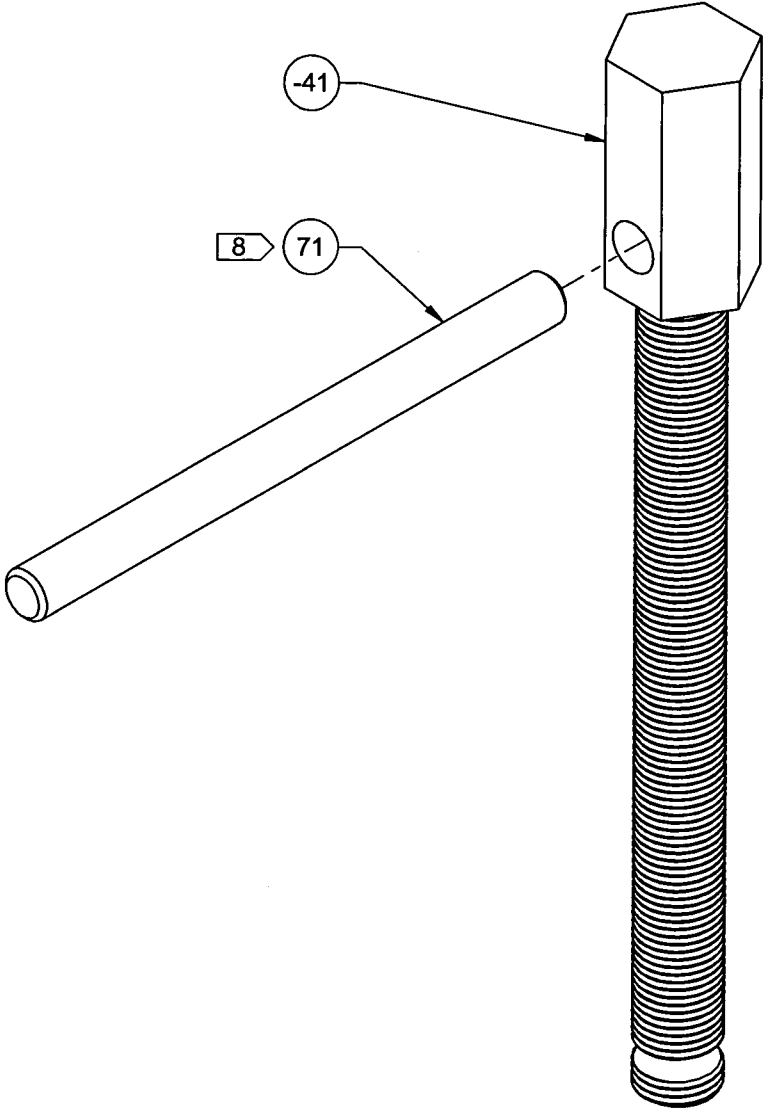
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) INSTALL ITEMS 69 HAND TIGHT
 - 10) PRESS FIT ITEM 70 WITH ITEM -42
 - 11) ITEM -42 MUST ROTATE FREELY
 - 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RB 92700-10753-042-39 APU SPLINE INSTALL TOOL

12

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 40 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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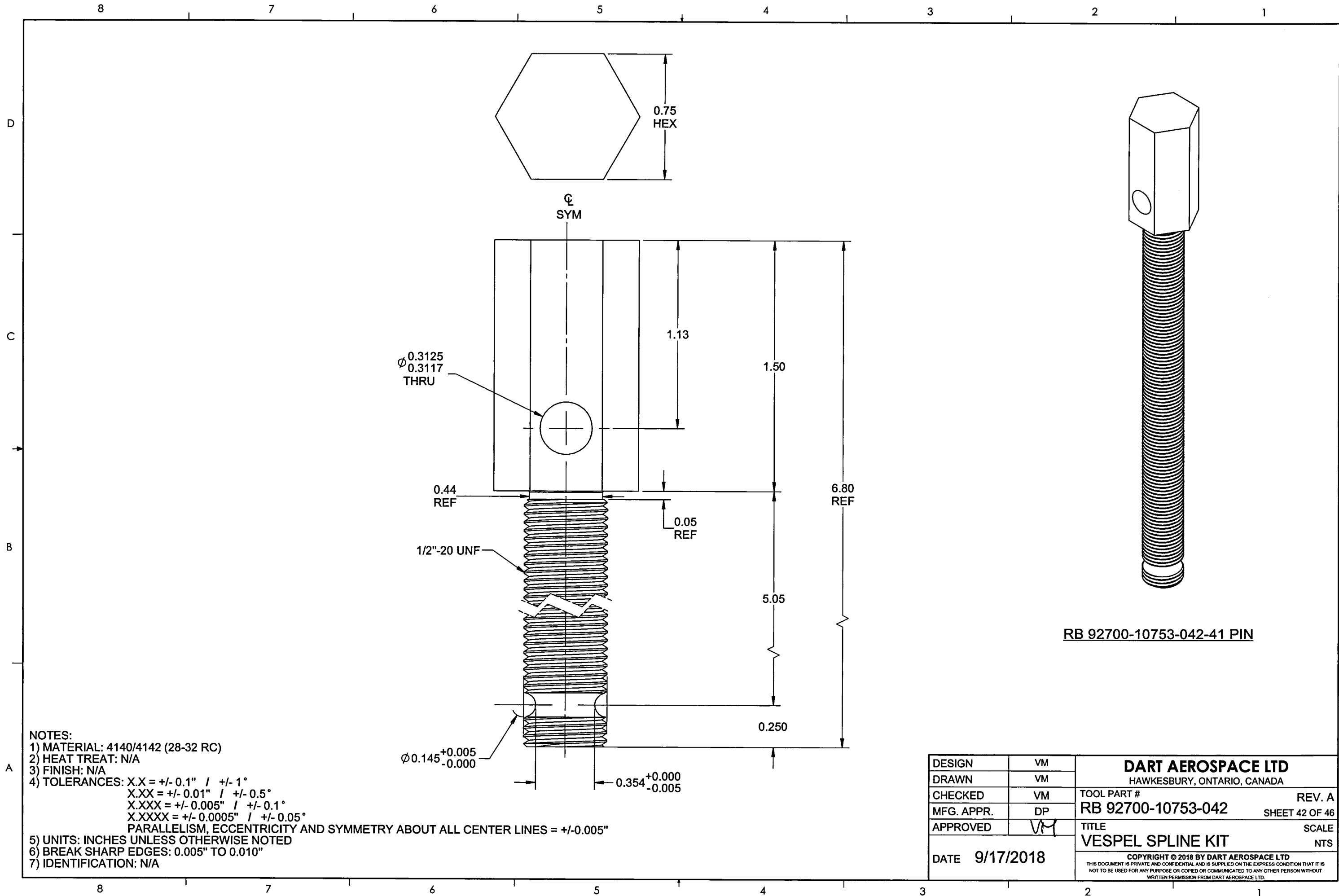
ITEM #	QTY	PART #	PART TITLE
-41	1	RB 92700-10753-042-41	PIN
71	1	McMaster#98381A599 OR EQUIV	STEEL DOWEL PIN 5/16" DIA. x 4" LG.



RB 92700-10753-042-40 HANDLE ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A
8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 71 CENTERED WITH ITEM -41 AS SHOWN AND REMOVE EXCESS

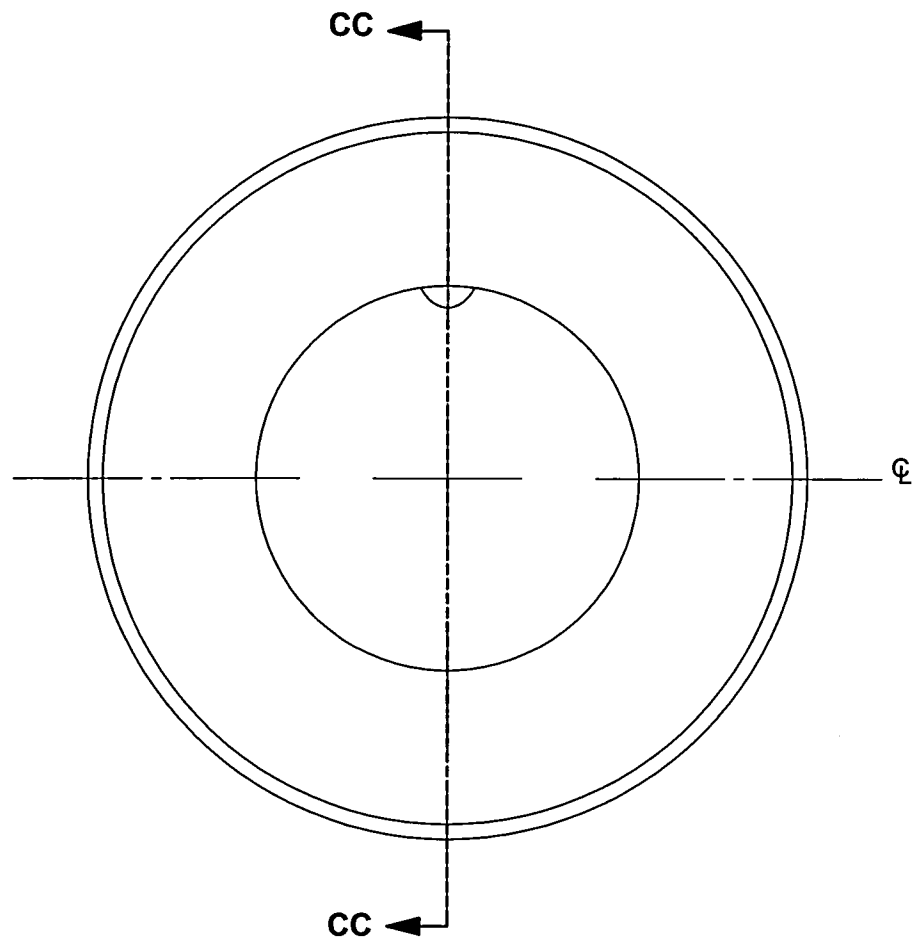
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 41 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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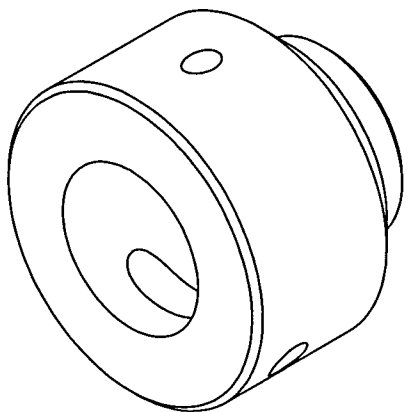
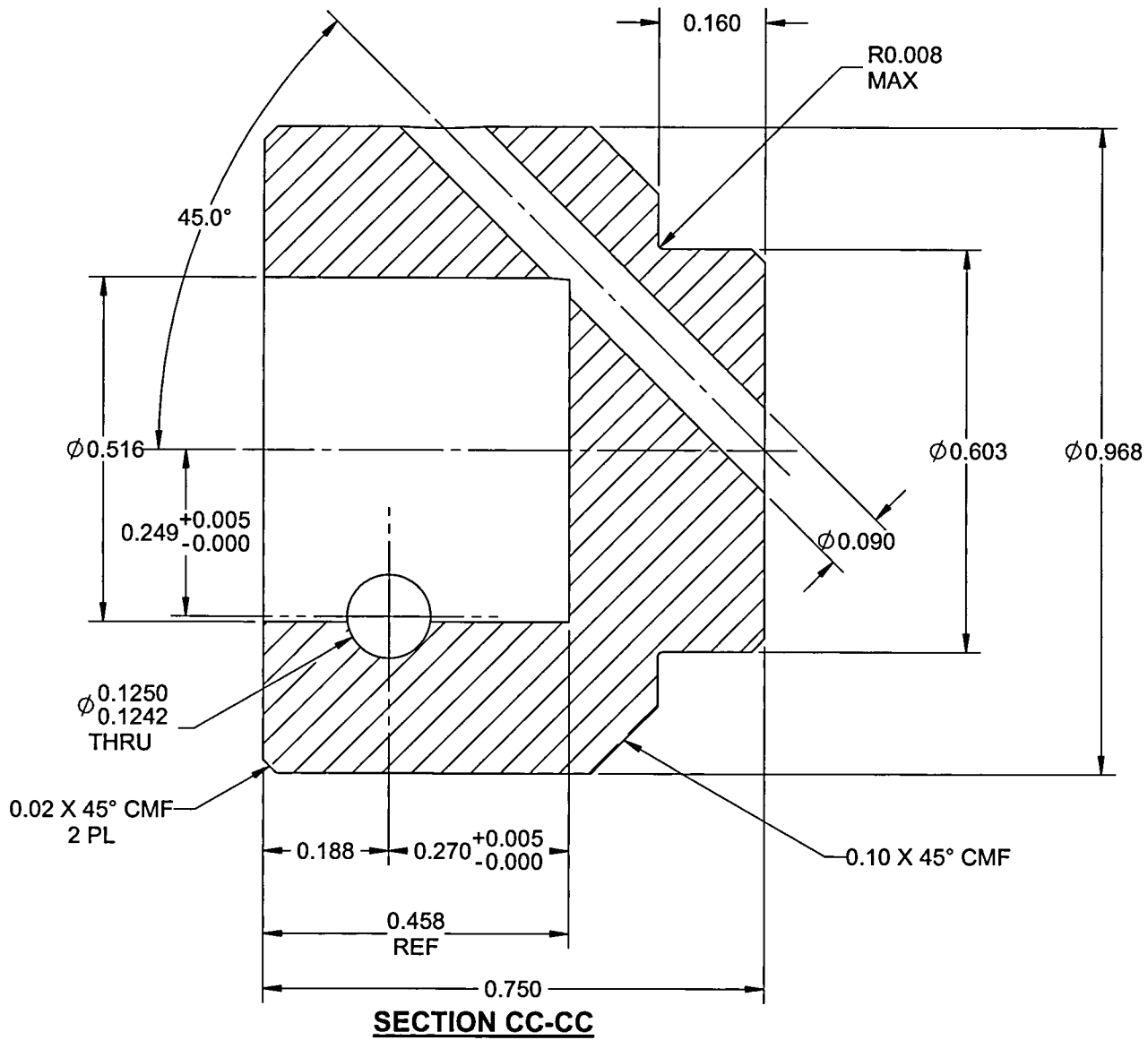
RB 92700-10753-042-41 PIN

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 42 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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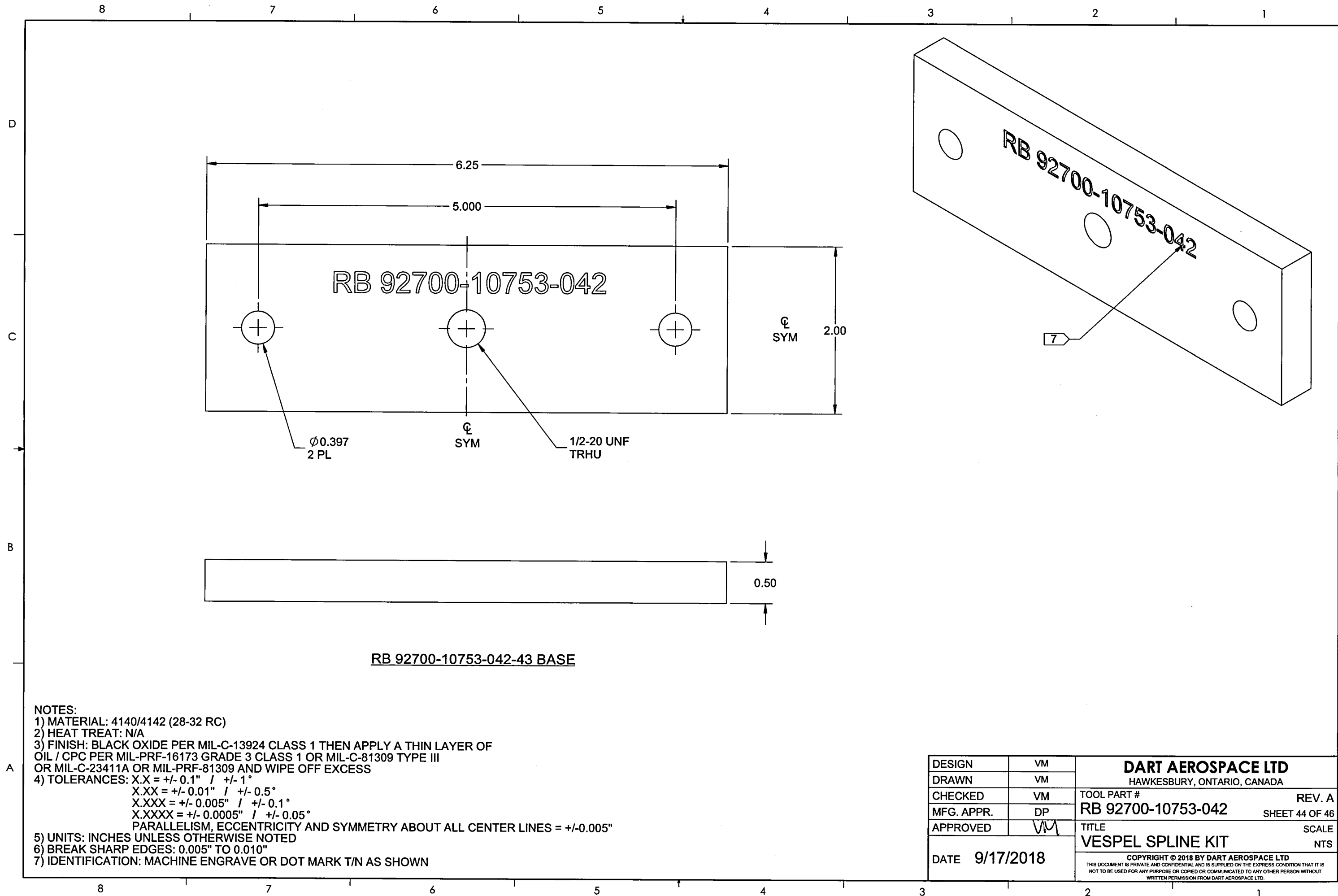


RB 92700-10753-042-42 PUSHER



NOTES:
1) MATERIAL: BRASS 360
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

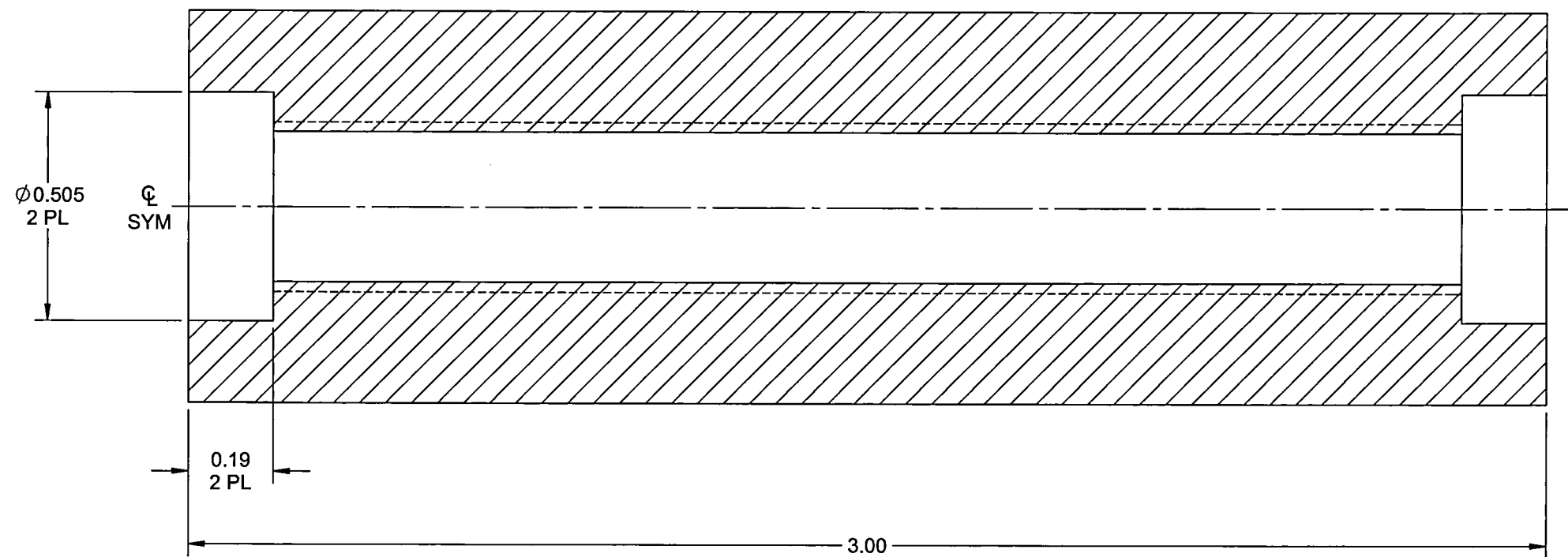
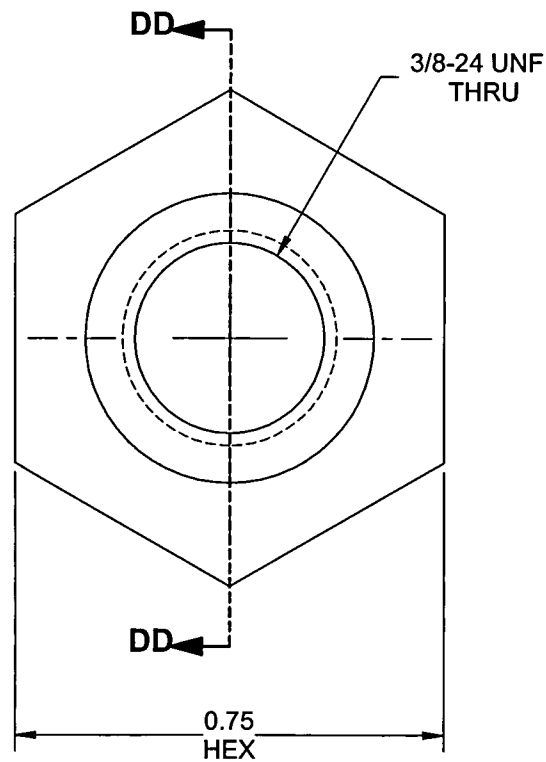
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 43 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 44 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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SECTION DD-DD

RB 92700-10753-042-44 LEG

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10753-042	SHEET 45 OF 46
APPROVED	VM	TITLE	SCALE
DATE 9/17/2018		VESPEL SPLINE KIT	NTS
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